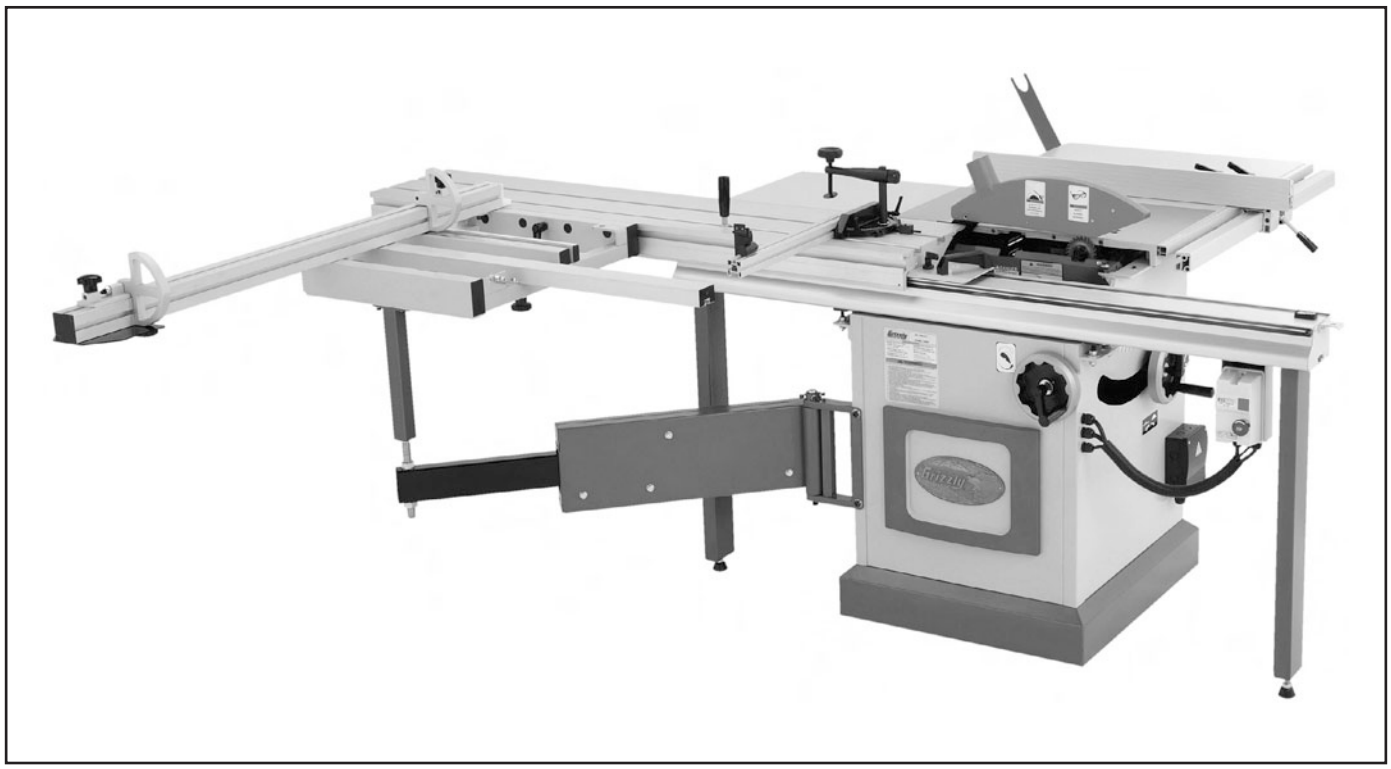
Grizzly Industrial, Inc.®

MODEL G0623X/G0623X3
10" SLIDING TABLE SAW
OWNER'S MANUAL



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#TR9147 PRINTED IN TAIWAN

⚠ WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

Failure to read, understand and follow the instructions given in this manual may result in serious personal injury, including amputation, electrocution or death.

The owner of this machine/equipment is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, blade/cutter integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

⚠ WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

MODEL G0623X-X3
10" SLIDING TABLE SAW
DADO BLADE INSTALLATION

When the manual was originally written, instructions for installing a dado blade were not used. The Model G0623X/G0623X3 has the capability of using 8" diameter dado blades up to 13/16" thick. The instructions in this update cover the installation process for dado blades.

Before operating your new machine, you MUST read and understand this manual update AND the original manual to reduce the risk of injury from improper use or setup. Since this update covers changes made toafter the owner's manual was printed, you MUST keep this update with your owner's manual for future reference. *If you have questions, contact Tech Support at (570) 546-9663 or by email at techsupport@grizzly.com.*

Dado Blade Installation

This saw can only accept a dado blade with 5/8" arbor hole and a maximum diameter of 8". The maximum width of dado blade that can be installed is 13/16". Attempting to install a dado blade that is sized larger than these maximum sizes is dangerous and should be avoided. If you have any doubts or questions about the size of dado blade you want to install, call our Technical Support before proceeding.

In order to install a dado blade, the scoring blade must be removed and a zero-clearance table insert must be made specifically for the dado blade you will install. If you plan on making dadoes at varying widths, we strongly recommend making a zero-clearance table insert for each thickness of dado blade that will be used. A zero clearance insert can be made for the saw in 30–60 minutes, and must be made of 3/4" furniture quality plywood or a hardwood.

WARNING: If you must use this saw to cut the dimensions of the zero-clearance insert you will fabricate in these instructions, make sure you DO NOT make any cuts while the included table insert is removed. **THIS IS DANGEROUS.** You must re-install the table insert, reassemble all saw components, and remove all tools before cutting.

Items Needed	Qty
Table Saw	1
Drill Press	1
Sander	1
Drill Bits 7/32" and 13/32"	1 Each
Plywood/Hardwood Piece 14" x 11/16" x 3/4"	1

To make a zero clearance table insert, do these steps:

1. DISCONNECT SAW FROM POWER

2. Lower the main blade all the way, remove the blade guard, riving knife, and scoring blade. After removing the scoring blade, reinstall and tighten the scoring blade flanges and arbor nut.

3. Remove the main blade and the mounting spacer behind it (see **Figure 1**).

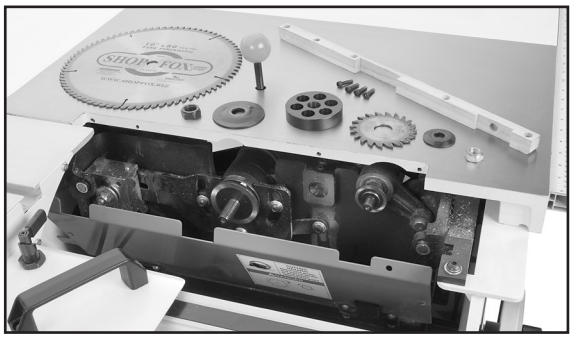

Figure 1. Existing insert removed.

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4. Remove the table insert that came with the saw.

5. Cut the new table insert to the exact length of the included table insert and 11⁄16" wide.

6. Use the included table insert as a template, as shown in **Figure 2**, to mark the mounting holes on the new table insert. (Clamping the pieces together while you do this will allow you to ensure the hole spacing is exact.)

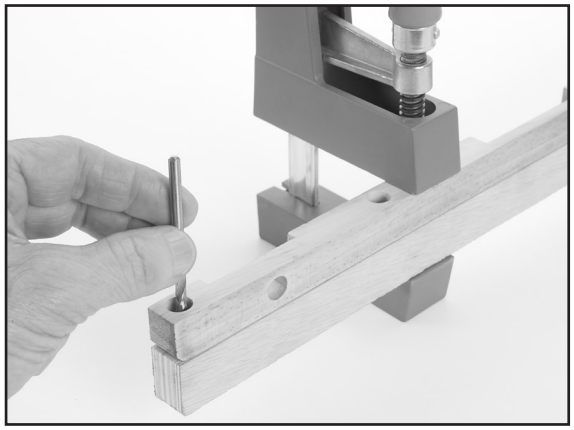


Figure 2. Marking location for mounting holes in new insert.

7. Use the 7⁄32" drill bit to drill holes completely through the new table insert.

8. Install the 13⁄32" drill bit and use the included table insert as a guide to set the depth stop on your drill press to countersink the holes.

9. Countersink the holes you drilled in **Step 7** (see **Figure 3**), so the heads of the mounting screws can be recessed into the table insert when installed.

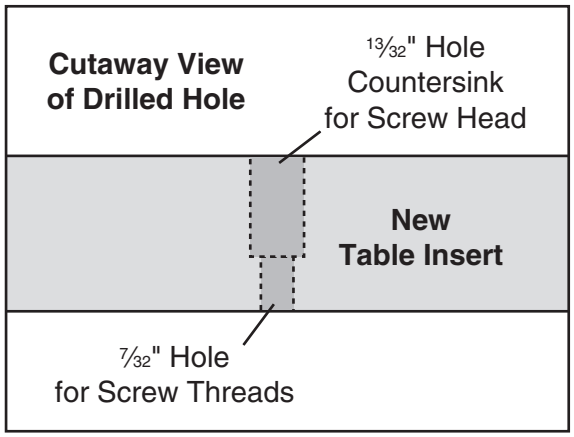


Figure 3. Countersinking mounting holes.

10. Install the dado blade at the thickness desired, making sure the blade flange is used on the front of the of the blade behind the arbor nut, then lower the blade completely.

11. Test fit the new table insert in the table, then sand the corners or trim the ends as necessary to get a precise fit.

12. Mount the new table insert into the table and check to make sure that it is flush with the top of the table. If necessary, remove the insert and sand the top of it down until it will mount up flush with the table top (see **Figure 4**).

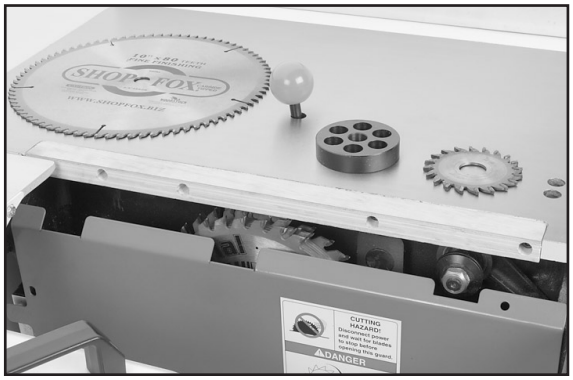


Figure 4. New zero clearance table insert installed.

13. Close the cover over the blade and move the sliding table to the center of the saw.

14. Connect the saw to power, start the motor, and slowly raise the blade into the zero clearance table insert (see **Figure 5**).

    Once the blade cuts through the top of the table insert, do not raise it higher than you anticipate your cuts to be. Doing so will compromise some of the zero-clearance qualities of your shop-made table insert once the blade is subsequently lowered.

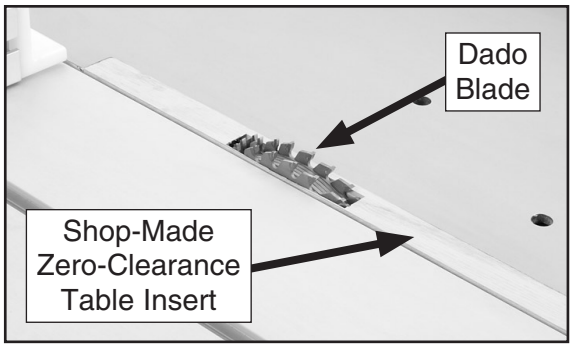
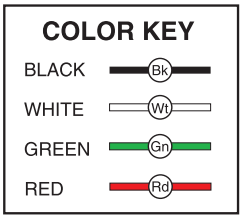


Figure 5. Dado blade raised into shop-made zero-clearance table insert.

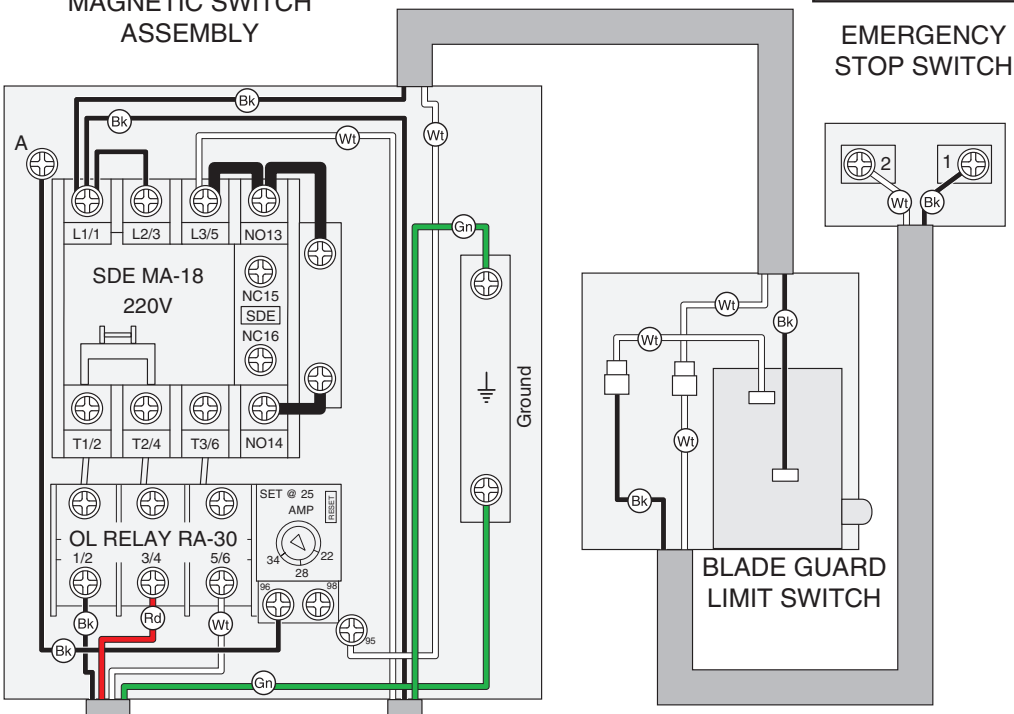
MODEL G0623X
10" SLIDING TABLE SAW
MANUAL/WIRING UPDATE

The wiring for the G0623X has been slightly modified since the manual was originally printed. If you own a Model G0623X that was manufactured after January of 2008, then this wiring diagram applies to your machine. *If you have any further questions about this manual update, contact our Technical Support at (570) 546-9663 or email techsupport@grizzly.com.*

MAGNETIC SWITCH ASSEMBLY



EMERGENCY STOP SWITCH



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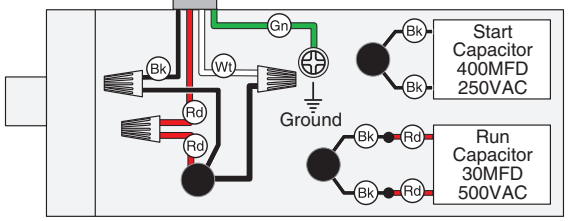
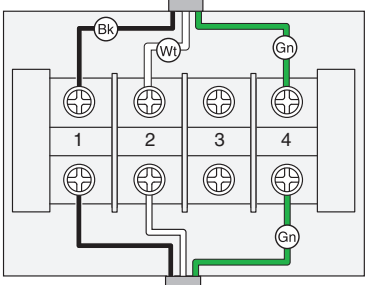
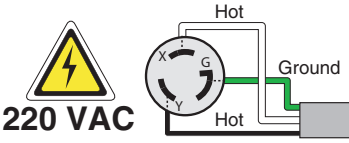


MOTOR 5HP 220V SINGLE-PHASE



POWER CONNECTION BOX



L6-30 PLUG (AS RECOMMENDED)

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INTRODUCTION

Foreword

We are proud to offer the Model G0623X/G0623X3 10" Sliding Table Saw. This machine is part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G0623X/G0623X3. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible.

The specifications, drawings, and photographs illustrated in this manual represent the Model G0623X/G0623X3 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

Contact Info

If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
C/O Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

We stand behind our machines. If you have any service questions or parts requests, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: http://www.grizzly.com

MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

MODEL G0623X
10" SLIDING TABLE SAW

Product Dimensions:

Weight	533 lbs.
Length/Width/Height	76" x 124¾" x 46"
Footprint with Legs (Width/Depth)	60" x 28"
Cabinet Footprint (Width/Depth)	25½" x 28"
Table Size without Extension Wings (Length/Width)	27" x 14⅜"
Table Size with Extension Wings (Length/Width)	47" x 40"
Sliding Table Size (Length/Width)	63" x 12¼"
Crosscut Fence Size (Length/Width)	78½" x ½"

Shipping Dimensions:

Number of Crates	2
Type	Cardboard/Wood
Content	Machine
Crate 1 Length/Width/Height	46" x 42" x 44"
Crate 1 Weight	528 lbs.
Crate 2 Length/Width/Height	67" x 18½" x 10"
Crate 2 Weight	117 lbs.

Electrical:

Switch Type	Magnetic With Thermal Overload Protection
Switch Voltage	220V
Cord Provided	No
Recommended Cord	10 gauge, 3 Wire, 300VAC
Recommended Circuit Size	30A
Plug Provided	No
Recommended Plug Type	L6-30

Motor

Type	TEFC Capacitor Start Induction
Horsepower	5 HP
Voltage	220V
Phase	Single
Amps	22A
Speed	3450 RPM
Cycle	60 Hz
Number Of Speeds	1
Power Transfer	V-Belt Drive
Bearings	Sealed and Lubricated

Main Specifications:

Capacities

Main Blade Arbor Diameter	5/8"
Main Blade Arbor Speed	4000 RPM
Main Blade Diameter	10"
Maximum Depth Of Cut At 90°	3 1/8"
Maximum Depth Of Cut At 45°	2 1/4"
Blade Tilt	0°–45°
Maximum Ripping Width With Standard Rip Fence	33"
Maximum Cross Cutting Width With Crosscut Fence	78 1/2"
Maximum Cross Cutting Length With Crosscut Fence	63"
Maximum Width Of Dado Cut	13/16"
Scoring Blade Arbor Diameter	22mm
Scoring Blade Arbor Speed	8000 RPM
Scoring Blade Diameter	3 1/8"

Construction

Sliding Table	Aluminum
Machine Frame	Steel
Fences	Extruded Aluminum Side, Aluminum Body
Rails	Hardened Steel
Trunnions	Cast Iron
Arbor Bearings	Sealed And Lubricated Ball Bearings

Other Specifications:

Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	Machine ID Label
Assembly Time	1 1/2 hrs.

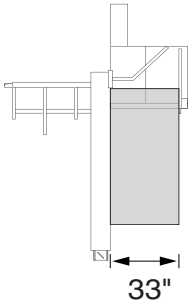
Features:

Blade Guard With 2 1/2" Dust Port
4" Main Dust Port
Adjustable Scoring Knife Kerf
Adjustable Riving Knife
Single Lever Locking Fence

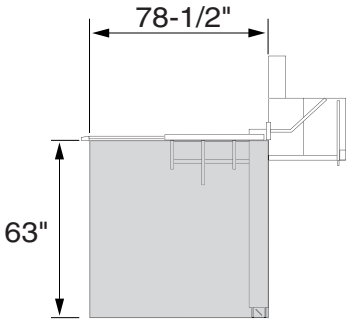
SLIDING TABLE SAW CAPACITIES

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

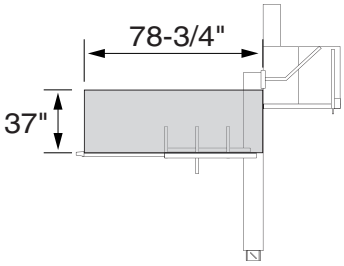
MODEL G0623X 10" SLIDING TABLE SAW



Ripping Width



Cross Cut



Miter Cut 90°
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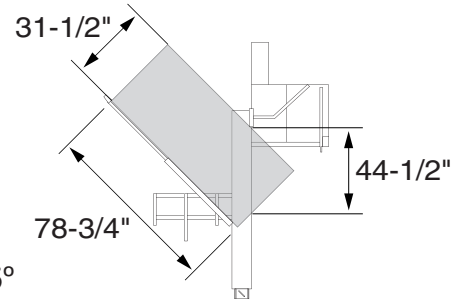

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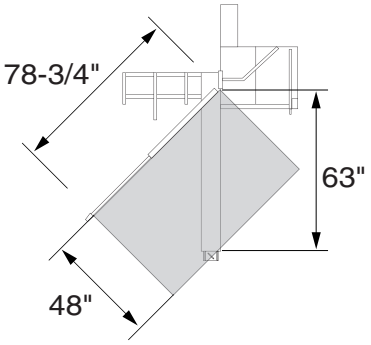
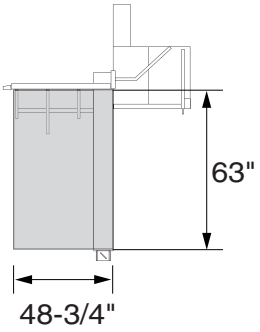
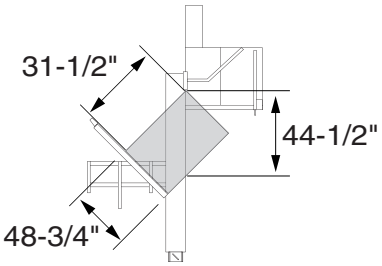


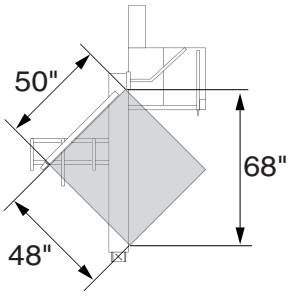
Miter Cut 45°



Cross Cut
(fence not extended)



Miter Cut 45°
(push cut, fence not extended)



Miter Cut 45°
(fence not extended)

MACHINE DATA SHEET

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Crate 2 Length/Width/Height	67" x 18½" x 10"
Crate 2 Weight	117 lbs.

Electrical:

Switch Type	Magnetic With Thermal Overload Protection
Switch Voltage	220V (can be converted to 440V with optional kit)
Cord Provided	No
Recommended Cord for 220V	10 gauge, 4 Wire, 300VAC
Recommended Cord for 440V	Qualified Electrician Must Hardwire
Recommended 220V Circuit Size	30A
Plug Provided	No
Recommended Plug Type for 220V	L15-30
Recommended Plug Type for 440V	Qualified Electrican Must Hardwire to Locking Disconnect Switch

Motor

Type	TEFC Induction
Horsepower	7.5 HP
Voltage	220V/440V
Prewired	220V
Phase	Three
Amps	20A @ 220V / 10A @ 440V
Speed	3450 RPM
Cycle	60 Hz
Number Of Speeds	1
Power Transfer	V-Belt Drive
Bearings	Sealed and Lubricated

Main Specifications:

Capacities

Main Blade Arbor Diameter	5/8"
Main Blade Arbor Speed	4000 RPM
Main Blade Diameter	10"
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Maximum Width Of Dado Cut	13/16"
Scoring Blade Arbor Diameter	22mm
Scoring Blade Arbor Speed	8000 RPM
Scoring Blade Diameter	3 1/8"

Construction

Sliding Table	Aluminum
Machine Frame	Steel
Fences	Extruded Aluminum Side, Aluminum Body
Rails	Hardened Steel
Trunnions	Cast Iron
Arbor Bearings	Sealed And Lubricated Ball Bearings

Other Specifications:

Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	Machine ID Label on Front of Machine
Customer Assembly & Setup Time	1½ hrs.

Features:

Blade Guard With 2½" Dust Port
4" Main Dust Port
Adjustable Scoring Knife Kerf
Adjustable Riving Knife
Single Lever Locking Fence

SLIDING TABLE SAW CAPACITIES

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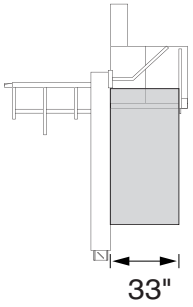
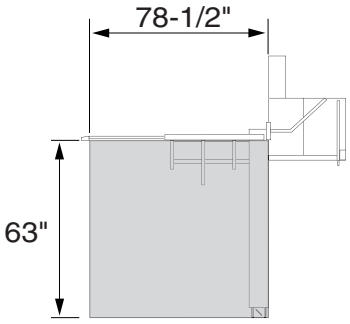
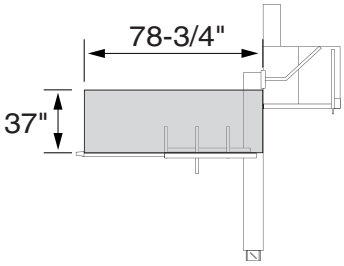


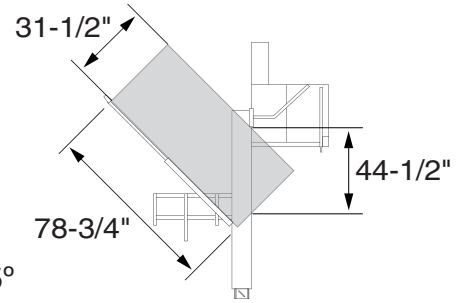
Ripping Width



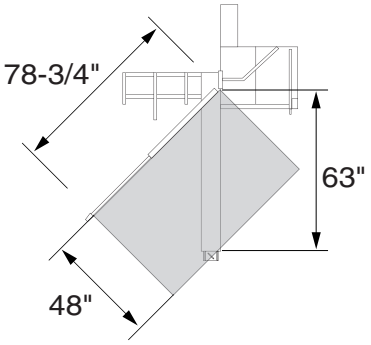
Cross Cut



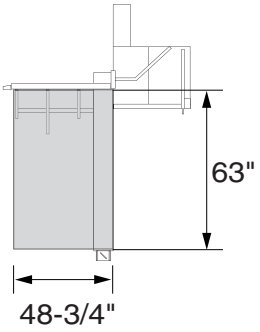
Miter Cut 90°
(push cut)



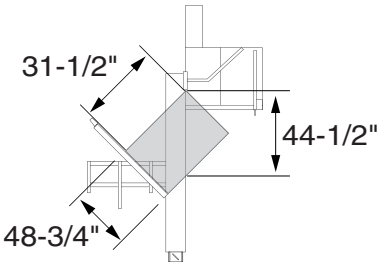
Miter Cut 45°
(push cut)



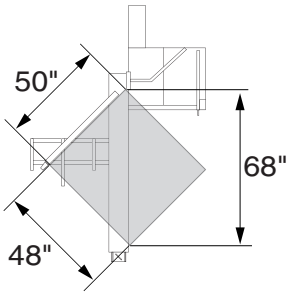
Miter Cut 45°



Cross Cut
(fence not extended)



Miter Cut 45°
(push cut, fence not extended)



Miter Cut 45°
(fence not extended)

Identification

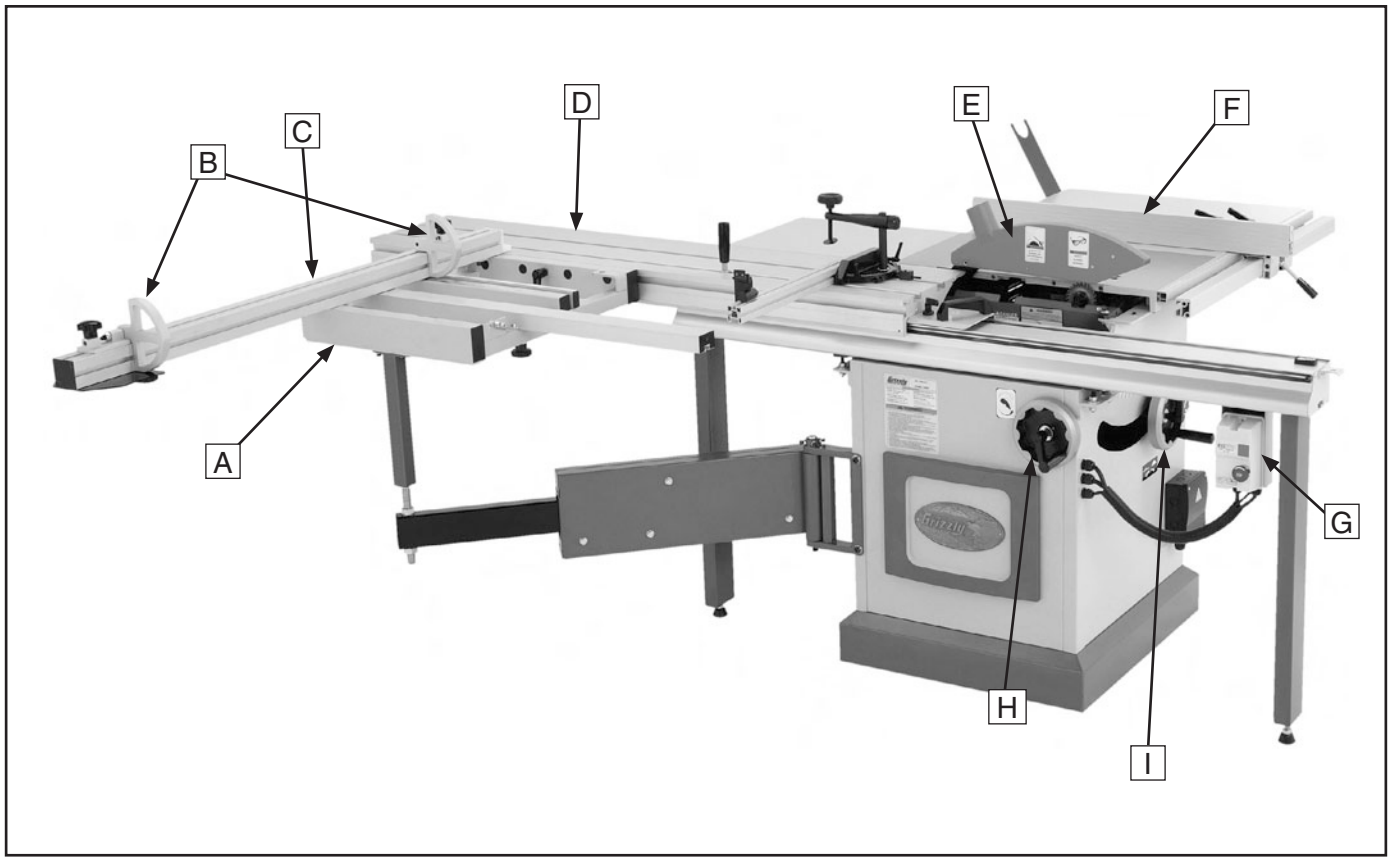


Figure 1. Main view of machine features and controls.

A. Crosscut Table—Provides a wide, stable platform for supporting full-size panels during crosscutting operations.

B. Flip Stops—Used for quick measurements for crosscutting.

C. Crosscut Fence—Used during crosscutting operations. Features a scale and multiple flip-style stop blocks for precise, repeatable crosscutting operations.

D. Sliding Table—Conveniently glides the workpiece through the blade with effortless precision and ease.

E. Blade Guard—Fully-adjustable blade guard maintains maximum protection around the saw blade and a 2½" dust port effectively extracts dust from the cutting operation.

F. Rip Fence—Fully adjustable with micro-adjustment knob for precision adjustments. Fence face can be positioned for standard cutting operations, or in the lower position for blade guard clearance during narrow ripping operations.

G. Switch—Features push-button controls starting and stopping the table saw motor.

H. Blade Angle Handwheel—Adjusts the angle of the saw blades.

I. Blade Elevation Handwheel—Located on the right-hand side of the cabinet, this handwheel adjusts the height of the main saw blade.

SECTION 1: SAFETY

⚠WARNING

For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

⚠DANGER **Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.**

⚠WARNING **Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.**

⚠CAUTION **Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.**

NOTICE **This symbol is used to alert the user to useful information about proper operation of the machine.**

⚠WARNING

Safety Instructions for Machinery

1. **READ THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
2. **ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses—they are NOT safety glasses.
3. **ALWAYS WEAR A NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Most types of dust (wood, metal, etc.) can cause severe respiratory illnesses.
4. **ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing loss.
5. **WEAR PROPER APPAREL.** DO NOT wear loose clothing, gloves, neckties, rings, or jewelry that can catch in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
6. **NEVER OPERATE MACHINERY WHEN TIRED OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.

⚠WARNING
Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.

8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.

9. **MAKE WORKSHOP CHILDPROOF.** Use padlocks, master switches, and remove start switch keys.

10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power ***OFF*** and allow all moving parts to come to a complete stop before leaving machine unattended.

11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.

12. **KEEP WORK AREA CLEAN AND WELL LIGHTED.** Clutter and dark shadows may cause accidents.

13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Grounded cords minimize shock hazards. Undersized cords create excessive heat. Always replace damaged extension cords.

14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY**. Make sure switch is in OFF position before reconnecting.

15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**

17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery ***ON***.

18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding or misaligned parts, broken parts, loose bolts, and any other conditions that may impair machine operation. Repair or replace damaged parts before operation.

19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. Improper accessories increase risk of injury.

20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.

21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.

22. **DO NOT OVERREACH.** Maintain stability and balance at all times.

23. **MANY MACHINES CAN EJECT WORKPIECES TOWARD OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."

24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY**.

25. **CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Be aware of the type of dust you are exposed to and always wear a respirator designed to filter that type of dust.

⚠WARNING
Additional Safety for Table Saws

1. **SAFETY ACCESSORIES.** Always use the blade guard and riving knife on all ''through-sawing'' operations. *Through-sawing operations are those when the blade cuts completely through the workpiece.* Always use a push stick when ripping narrow stock.

2. **KICKBACK.** Be familiar with kickback. Kickback happens when the workpiece is thrown towards the operator at a high rate of speed. *Until you have a clear understanding of kickback and how it occurs, DO NOT operate this table saw!*

3. **WORKPIECE CONTROL.** Make sure the workpiece is placed in a stable position on the table and is either supported by the rip fence or the crosscut table during cutting operations.

5. **OPERATOR POSITION.** Never stand or have any part of your body directly in-line with the cutting path of the saw blade.

6. **AWKWARD OPERATIONS.** Avoid awkward operations and hand positions where a sudden slip could cause your hand to move into the spinning saw blade.

7. **REACHING OVER SAW BLADE.** Never reach behind or over the blade with either hand while the saw is running. *If kickback occurs while reaching over the blade, hands or arms will be pulled into the spinning saw blade.*

8. **RIVING KNIFE ALIGNMENT.** Only operate the saw if the riving knife is aligned with the main blade.

9. **RIP FENCE AND CROSSCUT FENCE USAGE.** If using the rip fence as a stop block for the crosscut fence, the rip fence must be in front of the blade (see **Figure 68** on **Page 43).**

10. **CUT-OFF WORKPIECES.** Turn saw ***OFF*** before removing small workpiece cut-offs.

11. **BLADE HEIGHT.** Always adjust the blade to the proper height above the workpiece.

12. **DAMAGED SAW BLADES.** Never use blades that have been dropped or otherwise damaged.

13. **CUTTING CORRECT MATERIAL.** This machine is intended for cutting natural and man-made wood products, laminate covered wood products, and some plastics. Cutting drywall or cementitious backer board creates extremely fine dust and may reduce the life of the bearings. This machine is NOT designed to cut metal, glass, stone, tile, etc.; cutting these materials with a table saw may lead to injury.

14. **EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Service Department at (570) 546-9663.

⚠WARNING

Like all machines there is danger associated with this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

⚠CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

Preventing Kickback

Below are tips to avoid the most common causes of kickback:

- Only cut workpieces with at least one smooth and straight edge. DO NOT cut excessively warped, cupped or twisted wood. If the workpiece warpage is questionable, always choose another workpiece.
- Never attempt freehand cuts. If the workpiece is not fed parallel with the blade, a kickback will likely occur. Always use the rip fence or cross cut fence to support the workpiece.
- Make sure the riving knife is aligned with the blade. A misaligned riving knife can cause the workpiece to catch or bind, increasing the chance of kickback. If you think that your riving knife is not aligned with the blade, check it immediately!
- Ensure that your table slides parallel with the blade; otherwise, the chances of kickback are greatly increased. Take the time to check and adjust the sliding table.
- Do not remove the riving knife. The riving knife maintains the kerf in the workpiece, reducing the chance of kickback.
- Keep the blade guard installed and in good working order.
- Feed cuts through to completion. Anytime you stop feeding a workpiece in the middle of a cut, the chance of kickback is greatly increased.

⚠WARNING

Statistics show that most common accidents among table saw users can be linked to kickback. Kickback is typically defined as the high-speed expulsion of stock from the table saw toward its operator. In addition to the danger of the operator or others in the area being struck by the flying stock, it is often the case that the operator's hands are pulled into the blade during the kickback.

Protecting Yourself From Kickback

Even if you know how to prevent kickback, it may still happen. Here are some tips to protect yourself if kickback DOES occur:

- Stand to the side of the blade during every cut. If a kickback does occur, the thrown workpiece usually travels directly in front of the blade.
- Wear safety glasses or a face shield. In the event of a kickback, your eyes and face are the most vulnerable part of your body.
- Never, for any reason, place your hand behind the blade. Should kickback occur, your hand will be pulled into the blade.
- Use a push stick to keep your hands farther away from the moving blade. If a kickback occurs, the push stick will most likely take the damage that your hand would have received.
- Use featherboards or anti-kickback devices to prevent or slow down kickback.

Glossary Of Terms

The following is a list of common definitions, terms and phrases used throughout this manual as they relate to this table saw and woodworking in general. Become familiar with these terms for assembling, adjusting or operating this machine. Your safety is **VERY** important to us at Grizzly!

Arbor: Metal shaft extending from the drive mechanism, to which saw blade is mounted.

Bevel Edge Cut: Tilting the arbor and saw blade to an angle between 0° and 45° to cut a beveled edge onto a workpiece.

Blade Guard: Metal or plastic safety device that mounts over the saw blade. Its function is to prevent the operator from coming into contact with the saw blade.

Crosscut: Cutting operation in which the crosscut fence is used to cut across the grain, or across the shortest width of the workpiece.

Dado Blade: Blade or set of blades that are used to cut grooves and rabbets.

Dado Cut: Cutting operation that uses a dado blade to cut a flat bottomed groove into the face of the workpiece.

Featherboard: Safety device used to keep the workpiece against the rip fence and against the table surface.

Kerf: The resulting cut or gap in the workpiece after the saw blade passes through during a cutting operation.

Kickback: An event in which the workpiece is propelled back towards the operator at a high rate of speed.

Parallel: Being an equal distance apart at every point along two given lines or planes. I.e. the rip fence face is parallel to the face of the saw blade.

Non-Through Cut: A sawing operation that requires the removal of the blade guard and riving knife. Dado and rabbet cuts are considered Non-Through Cuts because the blade does not protrude above the top face of the wood stock. Deep Non-Through Cuts must be made with multiple, light passes to reduce chance of kickback. Always remember to re-install the blade guard and riving knife after performing a non-through cut.

Perpendicular: Lines or planes that intersect and form right angles (i.e. the blade is perpendicular to the table surface).

Push Stick: Safety device used to push the workpiece through a cutting operation. Used most often when rip cutting thin workpieces.

Rabbet: Cutting operation that creates an L-shaped channel along the edge of the workpiece.

Riving Knife (Splitter): Metal plate located behind the blade. It maintains the kerf opening in the wood when performing a cutting operation.

Straightedge: A tool used to check the flatness, parallelism, or consistency of a surface(s).

Through Cut: A sawing operation in which the workpiece is completely sawn through.

Rip Cut: Cutting operation in which the rip fence is used to cut with the grain, or across the widest width of the workpiece.

SECTION 2: CIRCUIT REQUIREMENTS

G0623X 220V Single-Phase

⚠WARNING

Serious personal injury could occur if you connect the machine to the power source before you have completed the setup process. DO NOT connect the machine to the power source until instructed to do so.

Amperage Draw

The Model G0623X motor draws the following amps under maximum load:

Motor Draw at 220V .....22 Amps

Circuit Requirements

We recommend connecting your machine to a dedicated and grounded circuit that is rated for the amperage given below. Never replace a circuit breaker on an existing circuit with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. **If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, consult a qualified electrician.**

Minimum Circuit Size.....30 Amps

Plug/Receptacle Type

Recommended Plug/Receptacle....NEMA L6-30

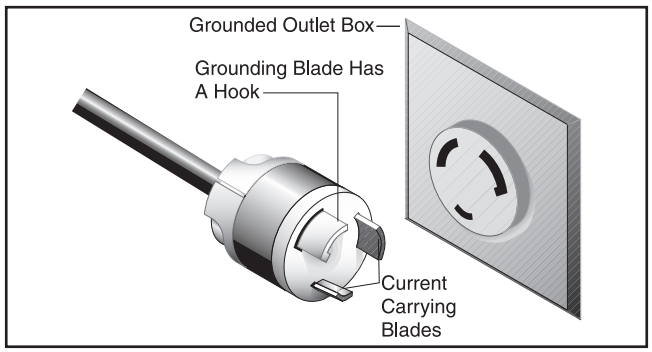


Figure 2. NEMA L6-30 plug and receptacle.

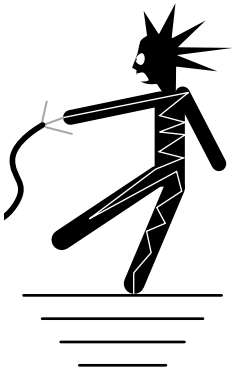
Power Cord Requirements

Use a stranded-copper flexible cord that meets the minimum requirements listed below, does not exceed 50 ft., and has an insulation type that starts with "S." A qualified electrician MUST determine the best cord to use in your environment depending on exposure to moisture, heat, and oils.

G0623X 220V 1-Phase.....10/3 AWG, 300VAC

Grounding

In the event of an electrical short, grounding reduces the risk of electric shock. The grounding wire in the power cord must be properly connected to the grounding prong on the plug; likewise, the outlet must be properly installed and grounded. All electrical connections must be made in accordance with local codes and ordinances.



⚠WARNING

Electrocution or fire could result if this machine is not grounded correctly or if your electrical configuration does not comply with local and state codes. Ensure compliance by checking with a qualified electrician!

Extension Cords

Using extension cords may reduce the life of the motor. Instead, place the machine near a power source. If you must use an extension cord:

- Use at least a 10 gauge cord that does not exceed 50 feet in length.
- Ensure that the extension cord contains a ground wire and plug prong.

G0623X3 220/440V Operation

WARNING

Serious personal injury could occur if you connect the machine to the power source before you have completed the setup process. DO NOT connect the machine to the power source until instructed after setup.

WARNING

Electrocution or fire could result if this machine is not installed to code. You MUST ensure compliance by checking with a qualified electrician!

NOTICE

The Model G0623X3 is prewired for 220V operation. If you plan to use your machine at 440V, you MUST have a qualified electrician perform the 440V conversion described on Page 58.

Full Load Amp Draw

G0623X3 220V 3-Phase .....20 Amp
G0623X3 440V 3-Phase .....10 Amp

Circuit Requirements

You MUST connect your machine to a grounded circuit that is rated for the amperage given below. Never replace a circuit breaker on an existing circuit with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. **If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, consult a qualified electrician.**

Minimum Circuit Size (220V).....30 Amps
Minimum Circuit Size (440V).....15 Amps

Power Cord Requirements

For 220V connection, use a stranded-copper flexible cord that meets the minimum requirements listed below, does not exceed 50 ft., and has an insulation type that starts with "S." A qualified electrician MUST determine the best cord to use in your environment depending on exposure to moisture, heat, and oils.

For 440V connection, an electrician MUST hardwire the machine. The electrician who hardwires the machine will determine the appropriate wire to use inside the conduit.

G0623X3 220V 3-Phase .....10/4 AWG, 300VAC
G0623X3 440V 3-Phase ..... Electrician Hardwire

Power Connection Device

The power connection device depends on the type of installed or planned service. We recommend using one of the devices shown in **Figure 3**, depending on the voltage being used.

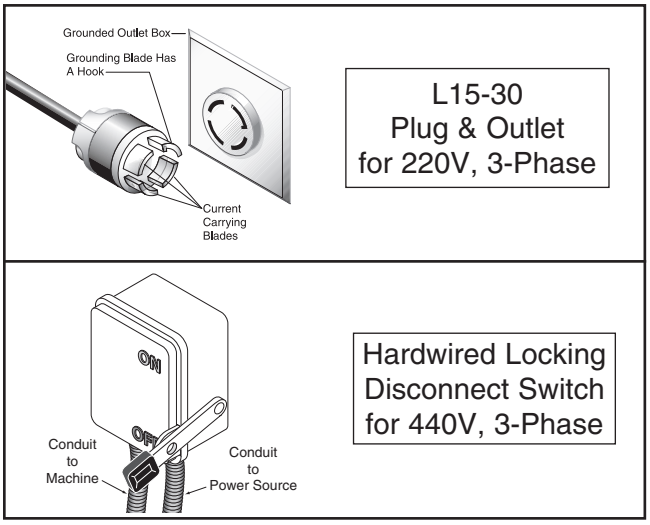


Figure 3. Recommended connection types.

Converting Model G0623X3 to 440V

The Model G0623X3 is prewired for 220V 3-phase operation, but it can be rewired for 440V operation.

To complete this conversion procedure, you must buy a 440V magnetic switch and rewire the motor for 440V operation. A 440V magnetic switch can be purchased from Grizzly by calling 1-800-523-4777. Refer to the parts breakdown in the back of this manual to find the correct 440V magnetic switch for your machine.

This rewiring job must be inspected by a qualified electrician before the saw is connected to the power source. Also, the junction box on the motor can be accessed easier for rewiring if the blade is moved to 0˚ (90˚ to table) before beginning.

⚠WARNING

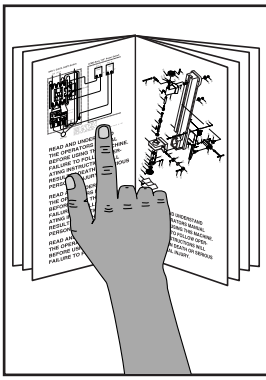
Serious personal injury could occur if you connect the machine to the power source before you have completed the setup process. DO NOT connect the machine to the power source until instructed after setup.

To rewire the machine for 440V operation:

1. DISCONNECT SAW FROM POWER!
2. Remove the cover of the magnetic switch.
3. Disconnect all the wires from the incoming power cords.
4. Remove the magnetic switch and install the new magnetic switch in the same manner as the old switch was installed. Refer to the wiring diagram on **Page 58** if you need help remembering where the wires are attached.
5. Remove the cabinet cover from the back of the machine.
6. Rewire the motor to 440V as shown in the diagram on **Page 58**.
7. Replace the junction box cover, cabinet door cover, and magnetic switch cover.

SECTION 3: SETUP

Setup Safety

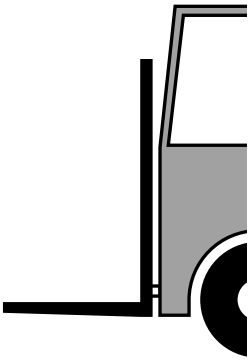


⚠WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!

⚠WARNING

Wear safety glasses during the entire set up process!



⚠WARNING

This machine weighs over 500 lbs. Serious personal injury may occur if safe moving methods are not followed.

To be safe, you will need another person for assistance and a forklift when moving the shipping crate and removing the machine from the crate.

Unpacking

The Model G0623X/G0623X3 was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, you should inventory the contents.

Items Needed For Setup

The following items are needed to complete the set up process, but are not included with your machine:

Description	Qty
• Safety Glasses (for each person)	1
• Forklift	1
• Lifting Straps	2
• An Assistant	1
• An Electrician	1
• Straightedge 4' (or longer)	1
• Hex Wrenches 3, 4, 5, 6, 8mm	1 Each

Inventory

After all the parts have been removed from the boxes in the crate, you should have the items listed below.

If any nonproprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

Inventory Item: (Figure 4)	Qty
A. Table Saw	1

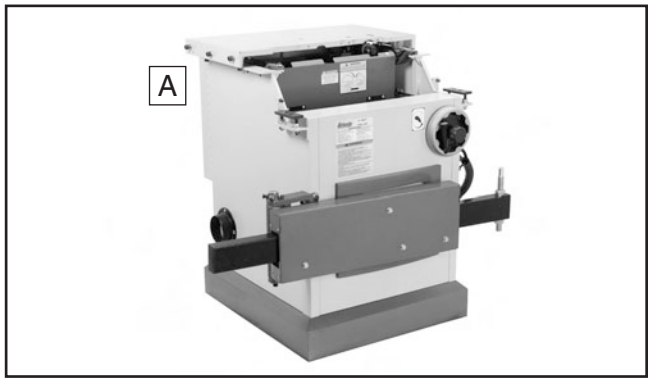


Figure 4. Table saw.

Inventory Item: (Figure 5)	Qty
B. Large Extension Table	1
C. Small Extension Table	1
D. Hose Support	1

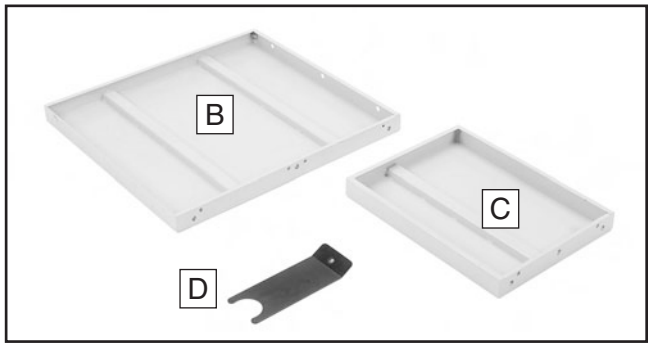


Figure 5. Extension table items.

Inventory item: (Figure 6)	Qty
E. Crosscut Fence	1
F. Support Bar	1
G. Crosscut Table	1
H. Crosscut Table Support Leg	1
I. Flip Stops	2
J. Lock Lever M12-1.75 x 55	1
K. Flat Washer 12mm	1
L. T-Nut M12-1.75	1

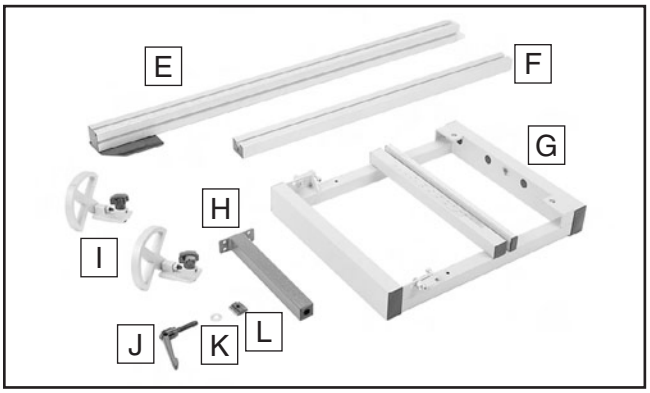


Figure 6. Crosscut table items.

Inventory Item: (Figure 7)	Qty
M. Rip Fence Rail	1
N. Rip Fence	1
O. Rip Fence Scale	1
P. Rip Fence Lever w/Hex Nut M8-1.25	1
Q. Rip Fence Base	1

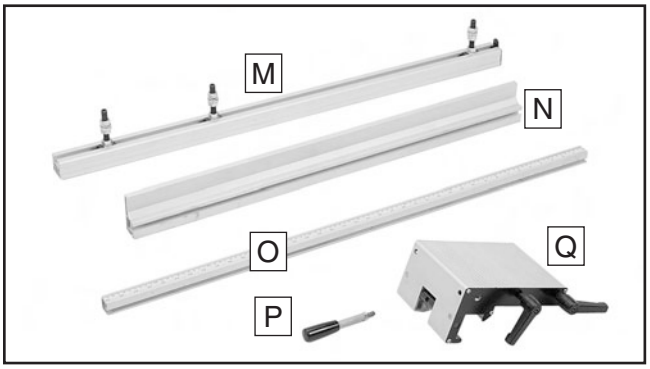


Figure 7. Rip fence items.

Inventory Item: (Figure 8)	Qty
R. Blade Guard w/Cap Screw & Nut	1
S. Arbor Lock Tool	1
T. Sliding Table Handle w/Lock	1
U. Push Stick	1
V. Riving Knife	1
W. End Cover	1
X. Wrench 17mm (not shown)	1
Y. Wrench 19/22mm (not shown)	1

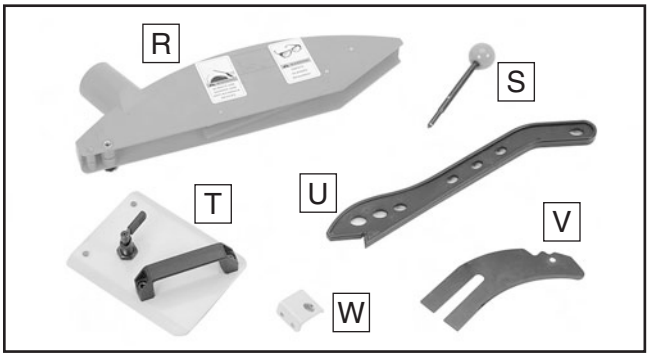


Figure 8. Miscellaneous components.

Inventory Item: (Figure 9)	Qty
AA. Miter Clamp	1
AB. Miter Flip Stop	1
AC. Miter Handle w/Flat Washer 8mm	1
AD. Miter Gauge Fence	1
AE. Miter Gauge Body	1
AF. Miter Guide Bar	1

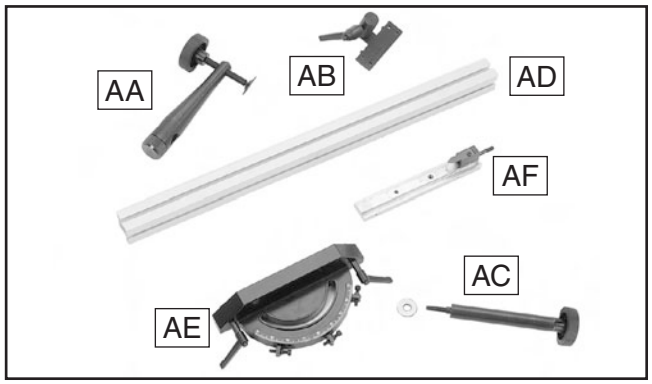


Figure 9. Miter gauge items.

Inventory Item: (Figure 10)	Qty
AG. Sliding Table	1
AH. Sliding Table Support Legs	2
AI. Feet M12-1.75 x 75 w/Nuts	2

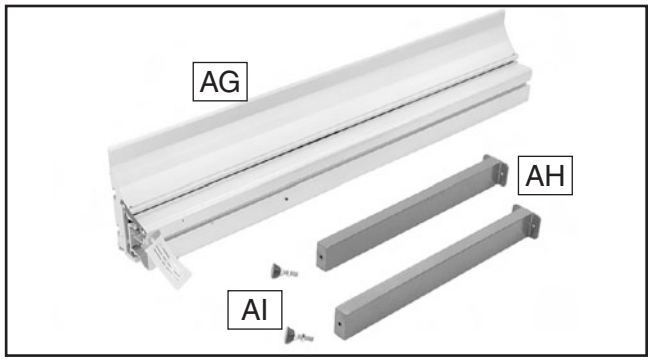


Figure 10. Sliding table items.

Inventory Item: (Figure 11)	Qty
AJ. Crosscut Brace Knobs M8-1.25 x 50	2
—Flat Washers 8mm	2
—Square Nuts M8-1.25	2
AK. Crosscut Fence Knob M8-1.25	1
—Flat Washer 8mm	1
—Crosscut Fence T-Stud M8-1.25 x 60	1
AL. Crosscut Fence Lock Knob M8-1.25 x 25	1
AM. Pivot Stud	1
—Special Washer 8 x 20mm	1
—Square Nut M8-1.25	1
AN. Push Handle M12-1.75 x 14	1
—Flat Washer 12mm	1
—Plastic Washer 12mm	1
—Push Handle T-Nut M12-1.75	1
AO. Support Leg T-Slot Plates	2
AP. Sliding Table T-Studs M12-1.75 x 35	2
—Flat Washers 12mm	2
—Lock Washers 12mm	2
—Hex Nuts M12-1.75	2

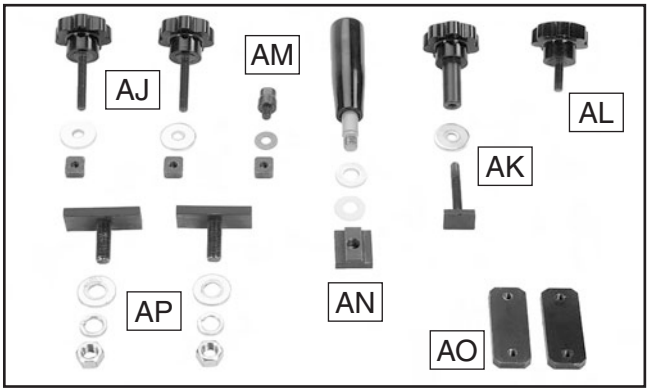
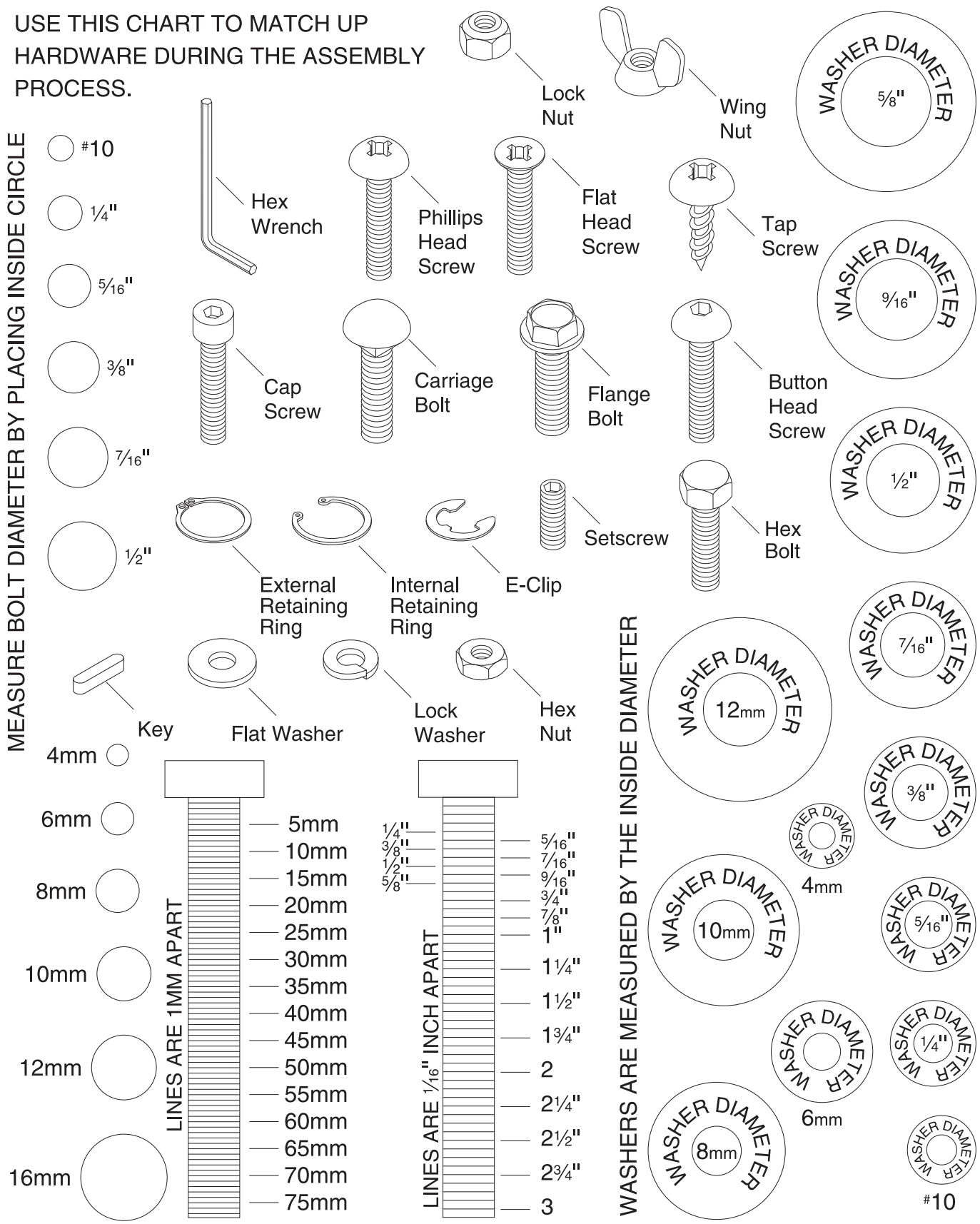


Figure 11. Miscellaneous knobs and hardware.

Other Hardware (not shown)	Qty
Cap Screws M10-1.5 x 25 (Extension Tables)	5
Flat Washers 10mm (Extension Tables)	5
Lock Washers 10mm (Extension Tables)	6
Set Screws M8-1.25 x 25 (Extension Tables)	6
Hex Nuts M8-1.25 (Extension Tables)	6
Hex Bolts M6-1 x 16 (Fence Scale)	2
Hex Bolt M6-1 x 25 (Fence Scale)	1
Flat Washers 6mm (Fence Scale)	3
Lock Washers 6mm (Fence Scale)	3
Hex Nuts M6-1 (Fence Scale)	3
Cap Screws M6-1 x 16 (CT Support Leg)	4
Lock Washers 6mm (CT Support Leg)	4
Flat Washers 6mm (CT Support Leg)	4
Cap Screws M5-.8 x 12 (Switch)	2
Lock Washers 5mm (Switch)	2
Cap Screws M10-1.5 x 30 (ST Leg Plates)	4
Lock Washers 10mm (ST Leg Plates)	4
Cap Screw M10-1.5 x 25 (Hose Support)	1
Flat Washers 10mm (Hose Support)	2
Hex Nut M10-1.5 (Hose Support)	1

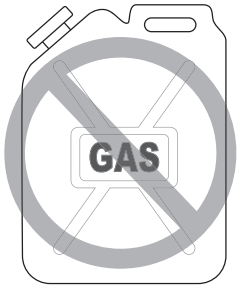
Hardware Recognition Chart

USE THIS CHART TO MATCH UP HARDWARE DURING THE ASSEMBLY PROCESS.



Clean Up

The unpainted surfaces are coated with a waxy oil to prevent corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Citrus Degreaser. To clean thoroughly, some parts must be removed. **For optimum performance from your machine, clean all moving parts or sliding contact surfaces.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner that may damage painted surfaces. Always follow the manufacturer's instructions when using any type of cleaning product.



⚠WARNING

Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. DO NOT use these products to clean the machinery.

⚠CAUTION

Many cleaning solvents are toxic if inhaled. Minimize your risk by only using these products in a well ventilated area.

G7895—Grizzly Citrus Degreaser
This natural, citrus-based degreaser is a great solution for removing export grease, and it's much safer to work around than nasty solvents.

Figure 12. Grizzly citrus degreaser.

Site Considerations

Floor Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some floors may require additional reinforcement to support both the machine and operator.

Placement Location

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 13** for the minimum working clearances.

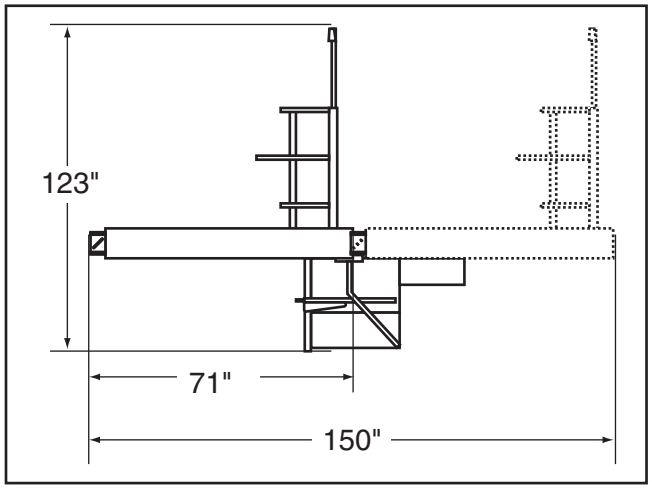
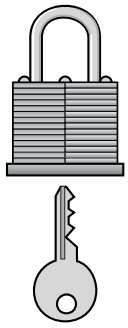


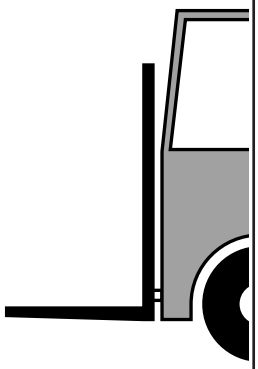
Figure 13. Minimum working clearances.



⚠CAUTION

Children and visitors may be seriously injured if unsupervised. Lock all entrances to the shop when you are away. DO NOT allow unsupervised children or visitors in your shop at any time!

Moving & Placing Table saw cabinet



⚠WARNING

This machine weighs over 500 lbs. Serious personal injury may occur if safe moving methods are not followed.

To be safe, you will need another person for assistance and a forklift when moving the shipping crate and removing the machine from the crate.

⚠WARNING

Make sure your lifting straps will hold the weight of the machine. If a lifting strap breaks, serious personal injury may occur.

To remove the saw base unit from the crate pallet:

1. Feed the lifting straps around the lifting bolts on the back of the table and the sliding table saw mounts on the front of the cabinet (see **Figure 14**). Attach the ends of the lifting straps to the forklift forks.

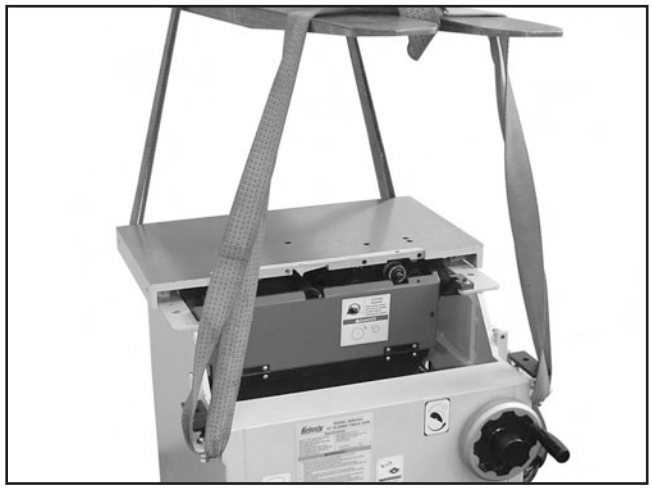


Figure 14. Lifting the table saw cabinet.

⚠WARNING

DO NOT lift the table saw any higher than necessary to clear the floor. Serious personal injury and damage to the machine may occur if safe moving methods are not followed.

2. Lift the table saw cabinet and move it to your predetermined location.

3. Remove the red lifting bolts from the back of the table.

4. Place a level on the cast iron table to level the table saw cabinet side-to-side and front-to-back. This will allow the table to slide smoothly.

   Note: *There are three options for leveling the saw: 1) Place it on a mobile base (Grizzly Model G7315) and use the mobile base controls to level it, 2) shim under the cabinet, and 3) thread bolts down into the nuts welded on the stand corners (**Figure 15**).*

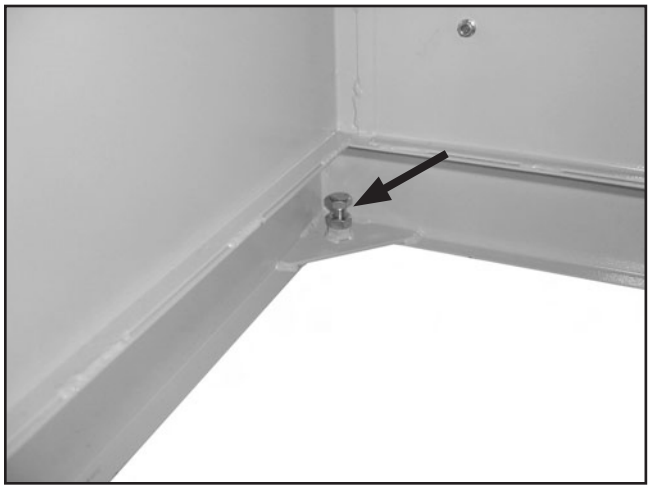


Figure 15. Hex bolt in stand corners for leveling; the hex nut is used to secure bolt position.

Assembly & Setup

Before shipping, the sliding table was installed on the machine and calibrated to the main table and blade. When the sliding table was removed for shipping, the lock nuts on the sliding table mounting brackets were carefully left in position to make re-installation easier. As such, be careful not to move any pre-installed nuts when installing the sliding table.

The sliding table and extension tables are heavy so you must get help lifting and holding them during the installation process. We recommend using a forklift or four strong helpers to lift the sliding table during installation.

To assemble the sliding table saw:

1. Place the sliding table on the cabinet.

2. On each side of the sliding table, slide a T-stud down the center bottom T-slot until it is next to the mounting bracket.

3. Lift one side of the sliding table, position the T-stud over the hole in the mounting bracket, then lower the sliding table so the T-stud fits through the hole, as shown in **Figure 16**. Repeat on the other side.

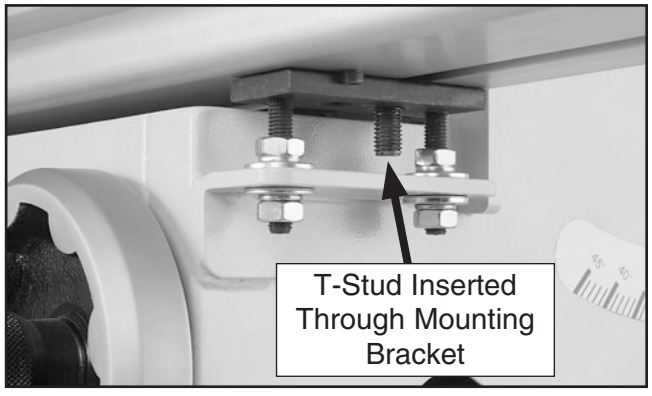


Figure 16. T-stud inserted in mounting bracket.

4. Put a 12mm flat washer, lock washer and hex nut onto the bottom of each T-stud and tighten the hex nut to secure the sliding table in place.

5. Install the small extension table with the two M10-1.5 x 25 cap screws, flat washers and lock washers (see **Figure 17**).

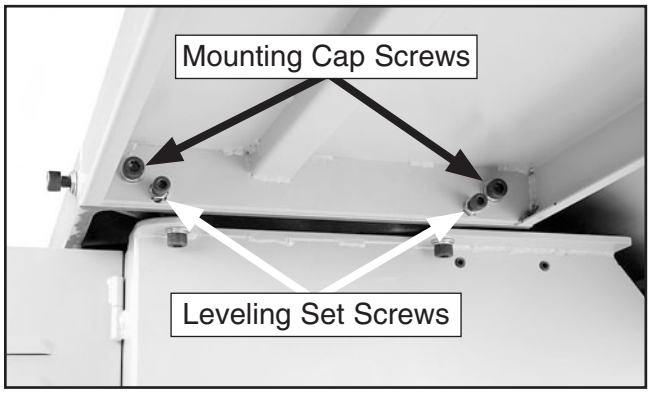


Figure 17. Small extension table installed.

6. Thread one M8-1.25 hex nut halfway onto each of the M8-1.25 x 25 set screws, then thread two of the set screws where shown in **Figure 17**, to act as leveling set screws in a later step.

7. Install the large extension table with the three M10-1.5 x 25 cap screws, flat washers, and lock washers (see **Figure 18**).

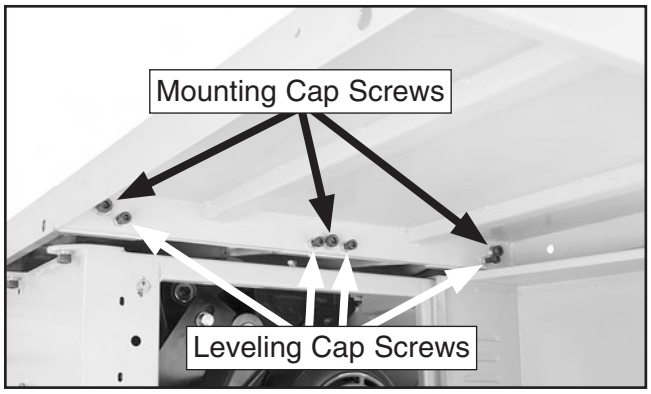


Figure 18. Large extension table installed.

8. Thread four M8-1.25 x 25 set screws with hex nuts where shown in **Figure 18**, to act as leveling set screws in a later step.

9. Level the top of the extension tables even with the top of the cast iron table.

Using a straightedge as a guide (**Figure 19**), adjust the leveling cap screws to align the top of extension tables with the top of the cast iron table. Tighten the hex nuts on the leveling cap screws against the extension table to lock the cap screws when the tables are aligned.

Figure 19. Extension wings mounted and even with cast iron table.

10. Mount the rip fence scale to the large extension table and cast iron table (**Figure 20**) using three 6mm hex nuts, lock washers, flat washers, two M6-1 x 16 hex bolts, and one M6-1 x 25 hex bolt. (The longer hex bolt is used in the cast iron table.) Secure the scale height so it is even with the table tops.

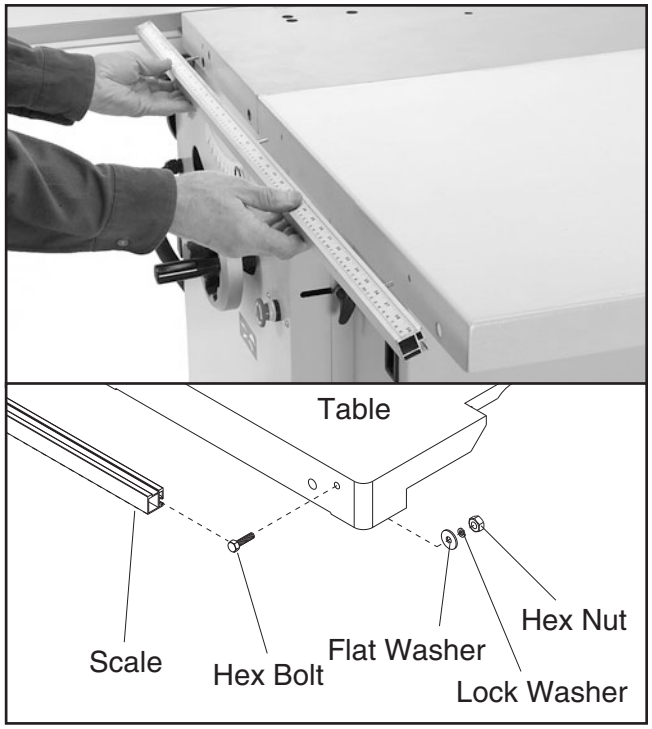


Figure 20. Mounting rip fence scale.

11. Mount the rip fence rail as shown in **Figure 21**. Make sure the black tab is toward the back end of the saw. Adjust the hex nuts so the gap between the rail and tables is even, but leave the rail slightly loose for now.

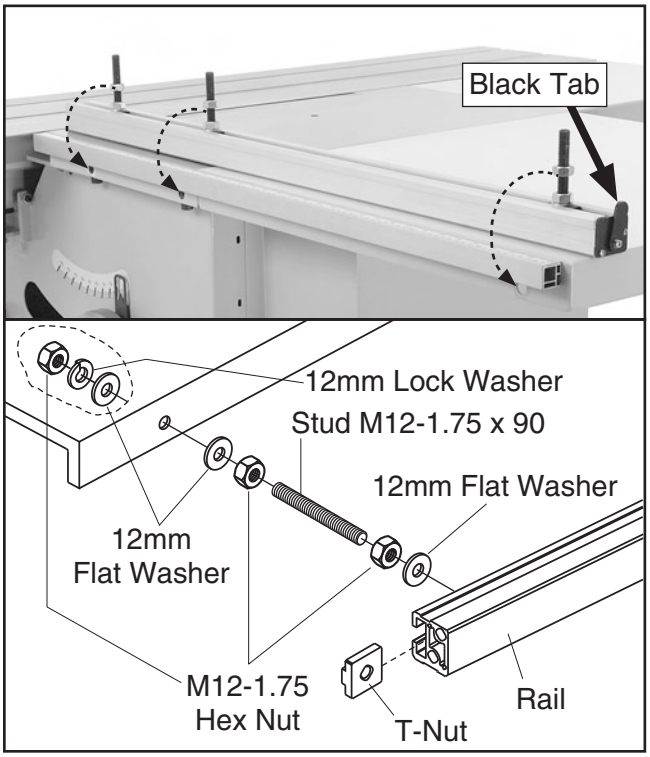


Figure 21. Rip fence rail mounting.

12. Slide the rip fence base on the rail, and check the spacing between the rip fence base and scale bar (see **Figure 22**). There should be a minimum of ⅛" of space between the scale bar and the fence base. Adjust the mounting position of the rip fence rail to create this space evenly along the length of the scale bar, then tighten the rail mounting nuts.

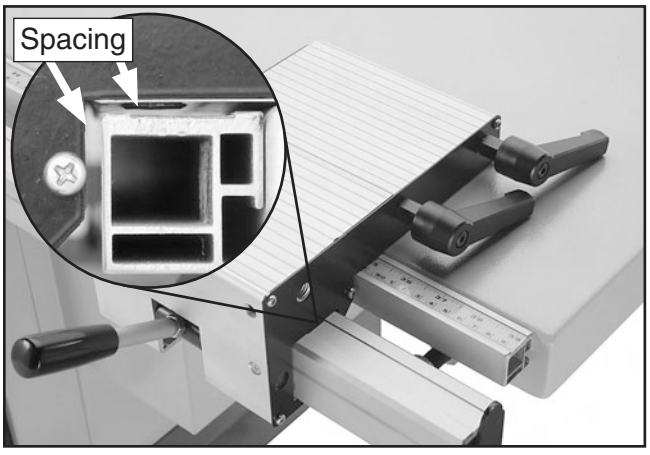


Figure 22. Fence base installed; spacing between fence base and scale bar.

Note: *The fence should slide smoothly on the rail; if it doesn't, remove the fence base and adjust the spring pressure plate mounting position on the fence base (see* ***Figure 23****).*

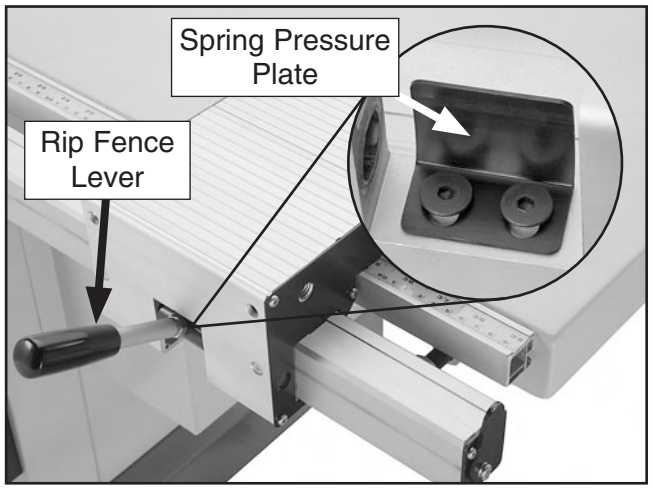


Figure 23. Location of spring pressure plate for fence slide adjustments.

13. Thread the rip fence lever into the fence base (**Figure 23**), tighten the hex nut against the rip fence base to keep the lever in place.

14. Slide the rip fence on the fence base T-bar as shown in **Figure 24**. Use the two lock levers on the opposite side of the fence base to secure the fence in position.

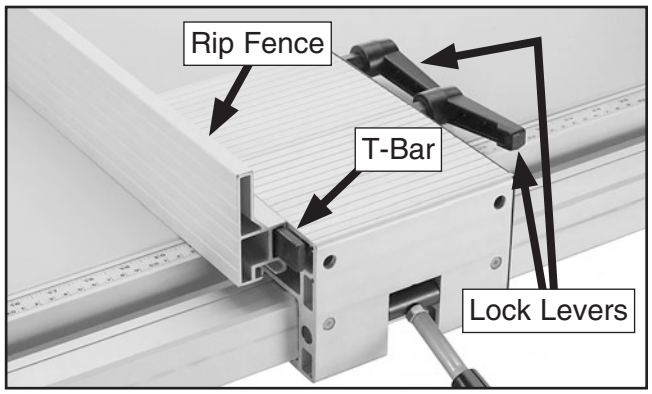


Figure 24. Rip fence installed on fence base.

15. Place a 12mm flat washer on the crosscut table lock lever, then insert it through the crosscut fence and thread the M12-1.75 T-nut onto the end approximately two turns.

16. Align the T-nuts on the crosscut table with the T-slot in the face of the sliding table, then slide the crosscut table into position on the sliding table (**Figure 25**) and tighten the crosscut table lock lever.

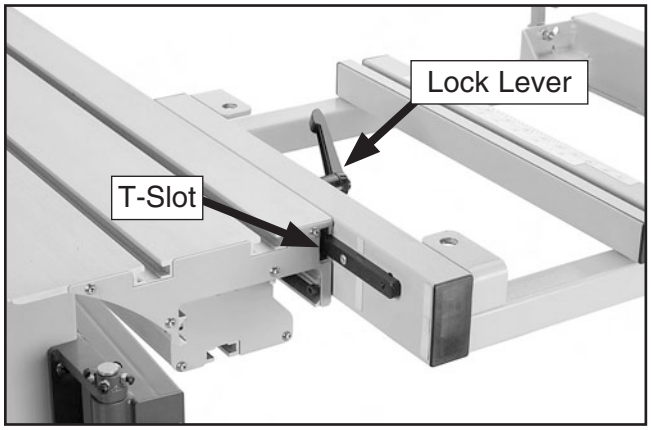


Figure 25. Crosscut table installation.

17. Place the crosscut table support leg on the extension arm, and attach it to the crosscut table with four M6-1 x 16 cap screws, 6mm lock washers, and 6mm flat washers.

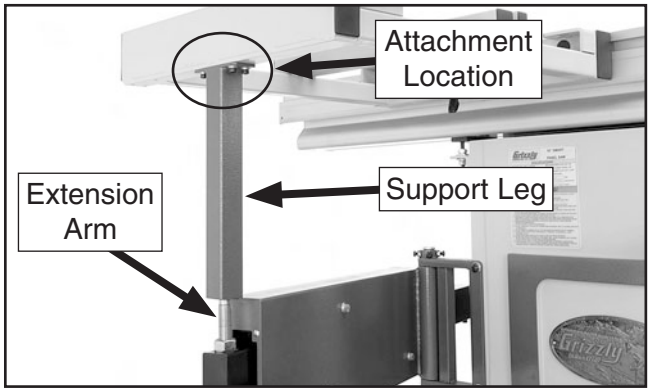


Figure 26. Support leg installed.

18. Insert the two crosscut brace knobs with 8mm flat washers through the crosscut table, then thread the square nuts onto the ends of the knob threads (**Figure 27, *A***). Slide the T-slot in the support bar over both T-nuts, and tighten the knobs (**Figure 27, *B***).

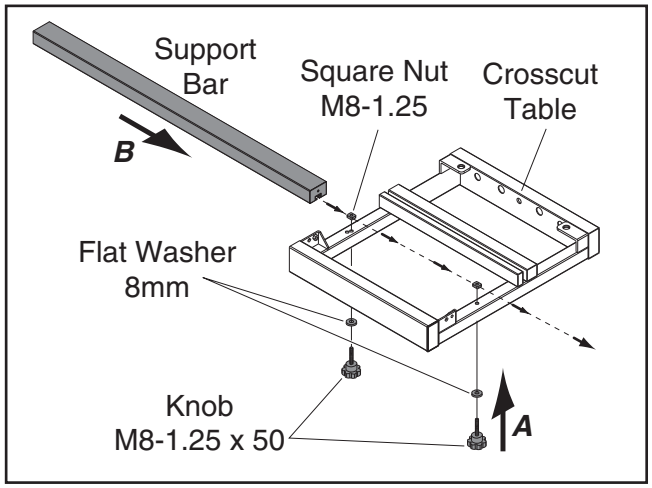


Figure 27. Installing support bar on crosscut table.

19. Slide the pivot stud assembly and the M8-1.25 x 60 T-bolt into the crosscut fence T-slot, as shown in **Figure 28**.

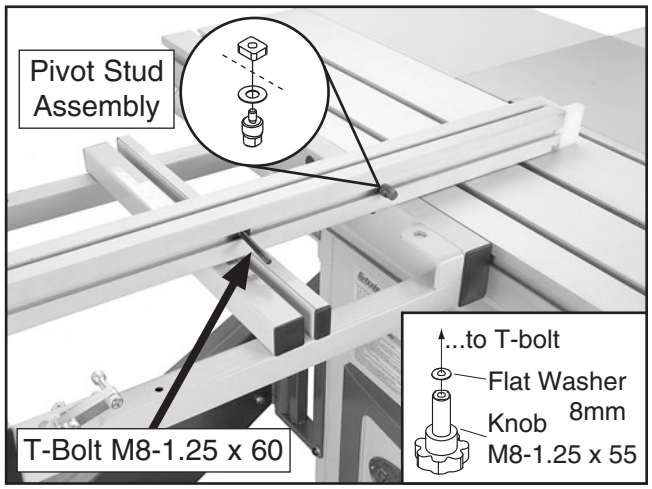


Figure 28. Pivot stud and T-bolt installed in crosscut fence.

20. Align the T-bolt and pivot stud with the crosscut table insertion points (**Figure 28**), and install the fence on the table.

21. Thread the M8-1.25 knob with an 8mm flat washer onto the bottom of the T-bolt from the underside of the table.

22. Hold the crosscut fence against the positive stop bolt, shown in **Figure 29**, then tighten the knob underneath the crosscut table to lock the crosscut fence in position.

Note: *This positive stop bolt can be fine-tuned later to ensure that the crosscut fence is square to the blade.*

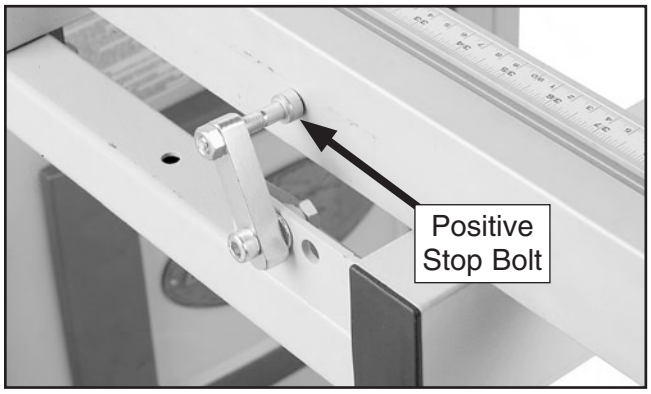


Figure 29. Positive stop bolt against the crosscut fence.

23. Install the flip stops in the T-slot on the crosscut fence, as shown in **Figure 30**, and use the crosscut fence lock knob to secure the extendable end of the fence in position.

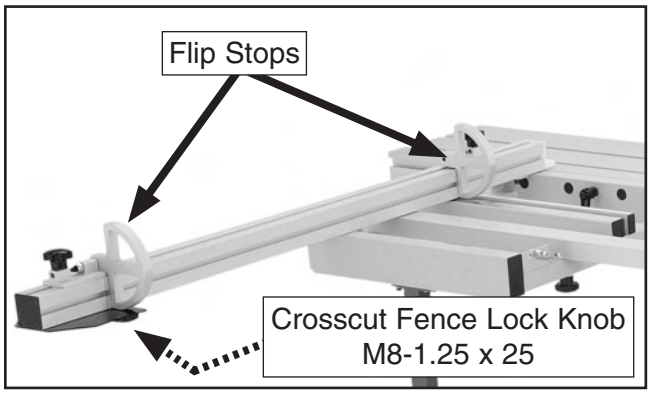


Figure 30. Flip stops installed on crosscut fence.

24. Remove the shipping brace from the sliding table (**Figure 31**), then install the sliding table end cover over the fixed part of the sliding table end, as shown in **Figure 32**, using the premounted hardware.

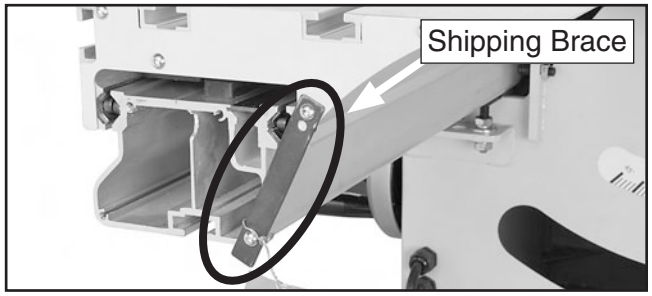


Figure 31. Sliding table shipping brace.

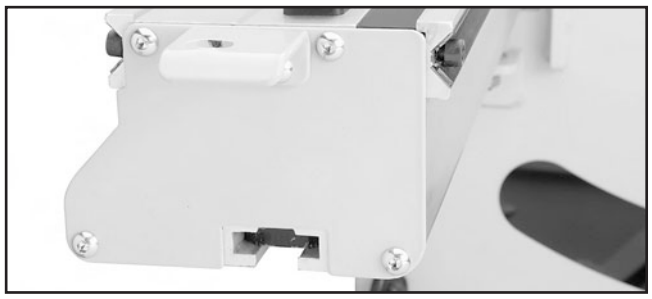


Figure 32. Sliding table end cover installed.

25. Attach the sliding table handle, as shown in **Figure 33**, with two button head screws and flat washers, using the premounted hardware.

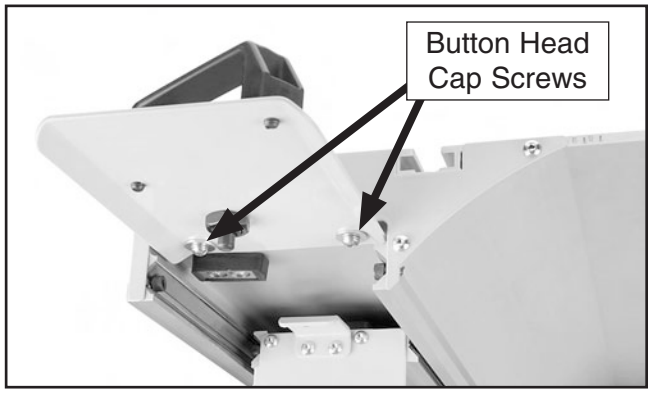


Figure 33. Sliding table handle attached to end of sliding table.

26. Thread two M5-.8 x 12 cap screws with 5mm lock washers through the switch bracket and into the sliding table base, and tighten the cap screws (see **Figure 34**).

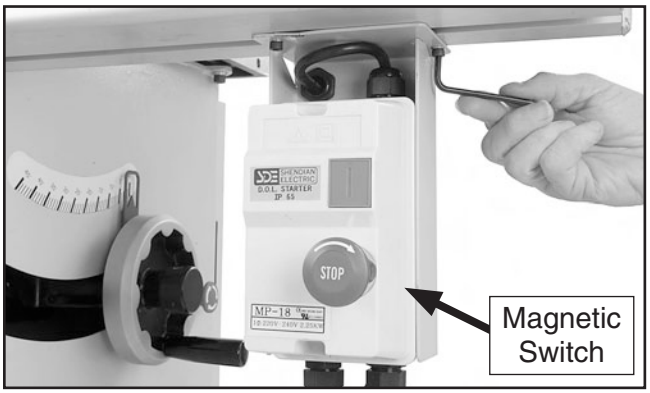


Figure 34. Magnetic switch installed.

27. Thread the feet all the way into the bottom of the support legs. DO NOT remove the hex nuts pre-installed on the bottom of the feet, since they will be used after the legs are installed.

28. Thread two M10-1.5 x 30 cap screws and 10mm lock washers through each support leg and part way into the T-slot plates for the legs, slide the T-slot plates into the both ends of the sliding table base, and tighten the mounting cap screws (see **Figure 35**).

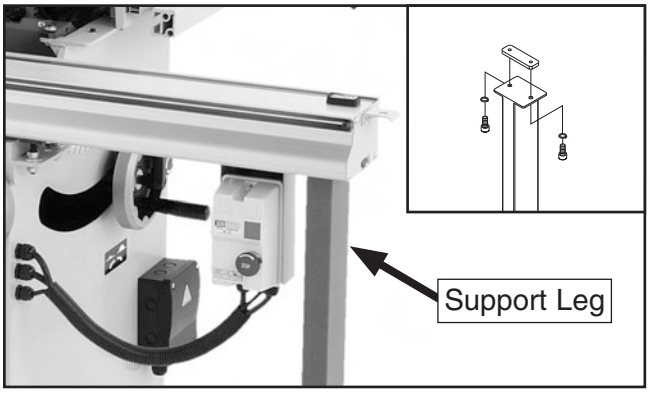


Figure 35. Support leg installed (1 of 2 shown).

29. Adjust the feet downward so they press against the floor, then tighten the hex nuts up against the support leg so the feet are locked in place.

30. Open the cabinet door and remove the motor shipping brace shown in **Figure 36**.

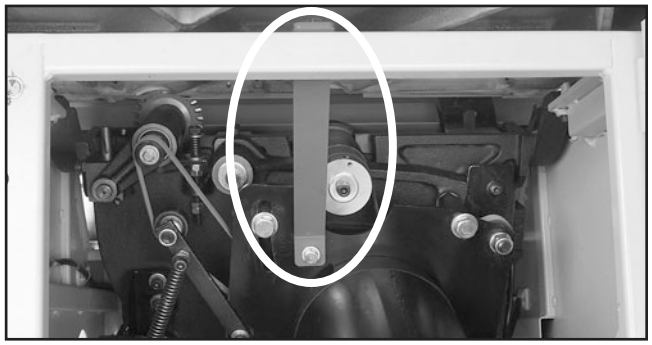


Figure 36. Motor shipping brace.

31. Tilt the blade assembly to 0˚, then slide the sliding table forward all the way until you can open the lower blade guard cover and access the blade arbors.

32. Insert the arbor lock tool into the hole shown in **Figure 37**, rotate the arbor until the arbor lock tool seats, then install the main blade, using the included arbor wrench. There MUST be an arbor flange on both sides of the blade.

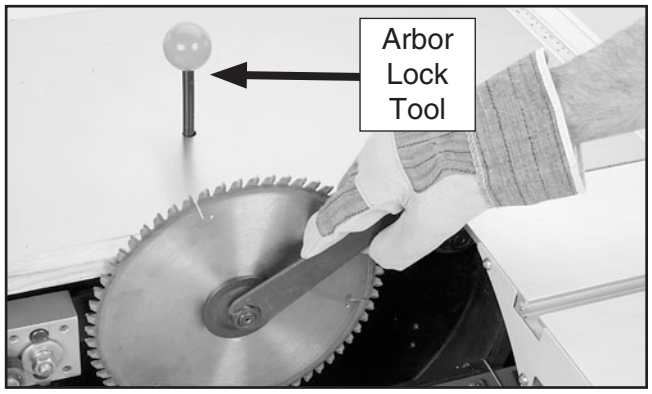


Figure 37. Installing main blade.

33. Insert the arbor lock tool into the hole shown in **Figure 38**, rotate the arbor until the arbor lock tool seats, then install the scoring blade, using the arbor wrench. There MUST be an arbor flange on both sides of the blade.

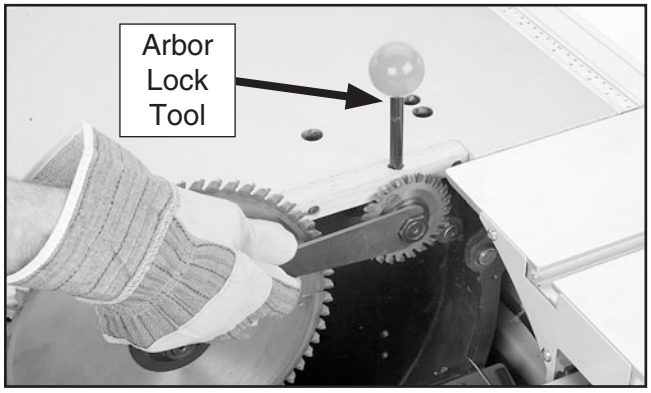


Figure 38. Installing scoring blade.

34. Install the riving knife as shown in **Figure 39**, but do not tighten the mounting bolt yet.

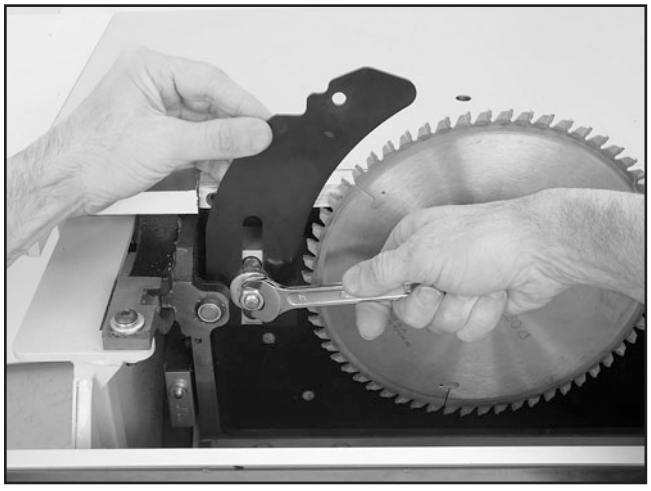


Figure 39. Installing riving knife.

35. Adjust the riving knife approximately ⅛" away from the main blade, using a ⅛" or 3mm hex wrench as a guide (**Figure 40**).

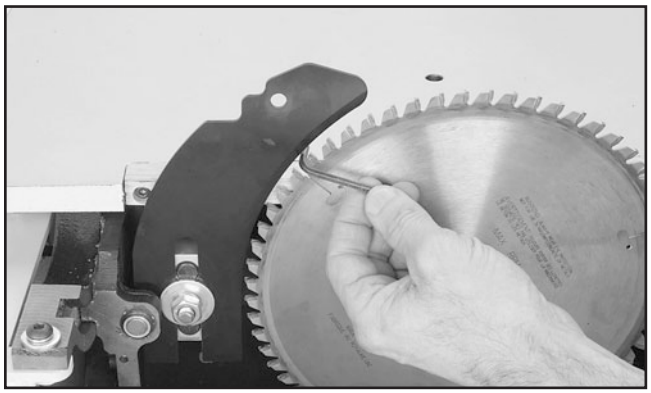


Figure 40. Adjusting the riving knife spacing.

36. Use a straightedge to make sure the riving knife and scoring blade are aligned with the main blade. The alignment should be with the blade bodies, not the carbide teeth.

—The riving knife position can be changed by adjusting the setscrews at the riving knife mounting block. Refer to **Page 38** for more details.

—The scoring blade alignment can be changed by adjusting the set screws accessible through the table top (see **Figure 41** or refer to **Page 39**).

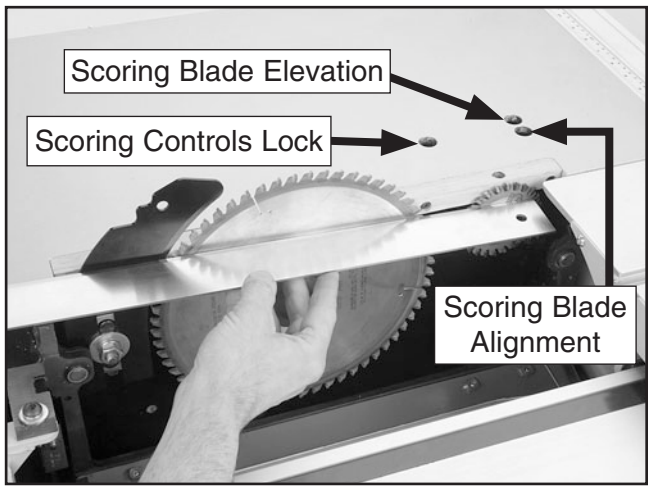


Figure 41. Access holes for scoring blade adjustment controls.

37. Install the blade guard on the riving knife, as shown in **Figure 42**, with the M8-1.25 x 40 button head cap screw shipped in the blade guard. (The blade guard/dust hood MUST be installed.)

Figure 42. Blade guard installed.

38. Assemble miter gauge and push handle as shown in **Figure 43**.

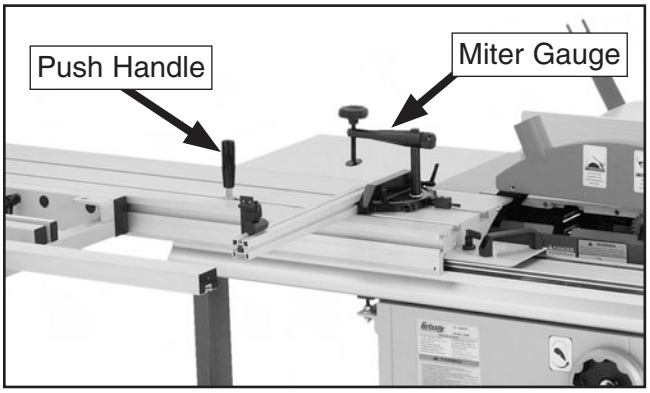


Figure 43. Push handle and miter gauge installed.

39. Install the hose support, as shown in **Figure 44**, with hardware shown below.

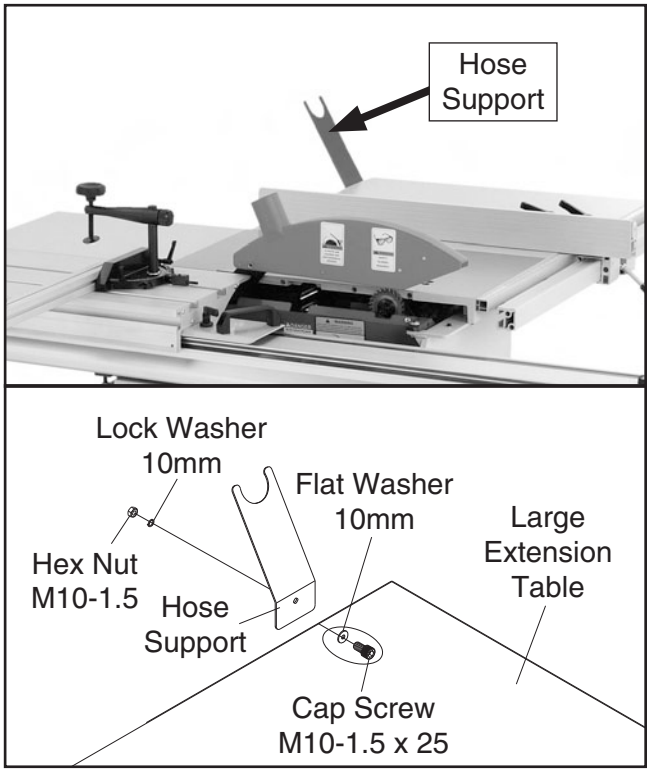


Figure 44. Hose support installed.

⚠CAUTION

DO NOT operate this saw without an adequate dust collection system. This saw creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Minimum CFM at 5" Dust Port:	**625 CFM**
Minimum CFM at 2½" Dust Port:	**150 CFM**

Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

40. Secure a 5" dust hose to the dust port located under the saw table (**Figure 45**).

Figure 45. 5" dust port location.

41. Attach a 2½" dust hose to the blade guard dust port, as shown in **Figure 46**.

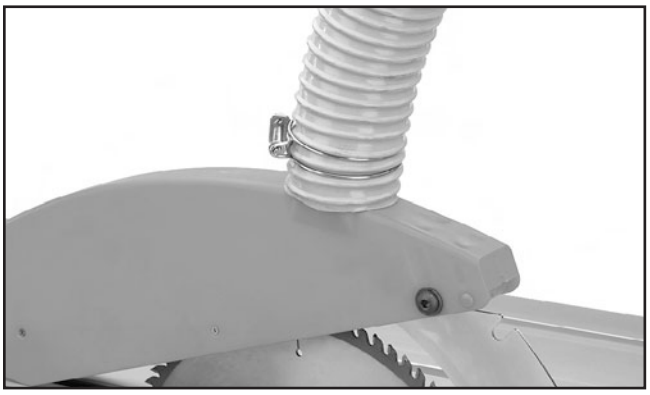


Figure 46. 2½" Dust port location.

42. Run the 2½" hose over the hose support, as shown in **Figure 47**.

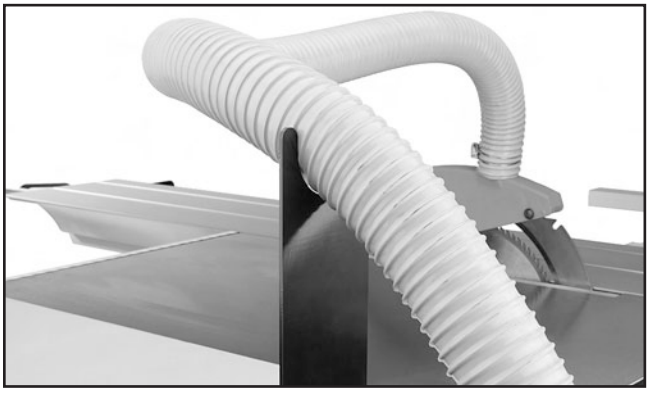


Figure 47. Dust hose support in use.

Power Connection

Before connecting the saw to power, read through **SECTION 2: CIRCUIT REQUIREMENTS** to check that your setup follows the safety and circuit requirements for your model.

Open the power connection box shown in **Figure 48**.

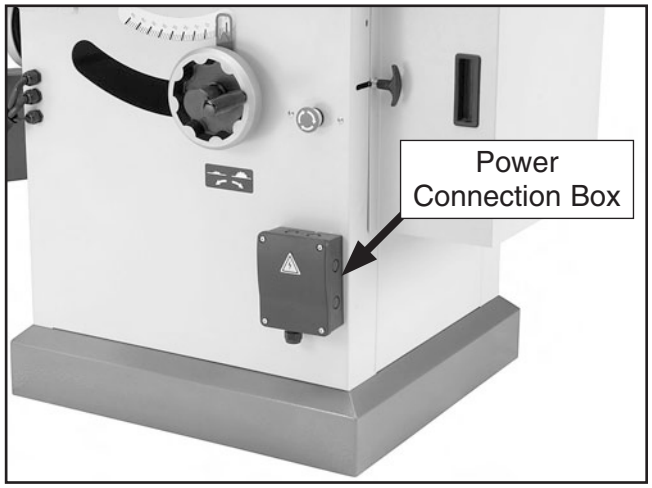


Figure 48. Power connection box.

Connect the power wires to the terminals shown in **Figure 49**, tighten the strain relief so the wires can't be pulled from the terminals, then close the power connection box.

Note for G0623X3: *If using a phase converter, connect the manufactured power leg to the S terminal to prevent damage (see **Page 15**).*

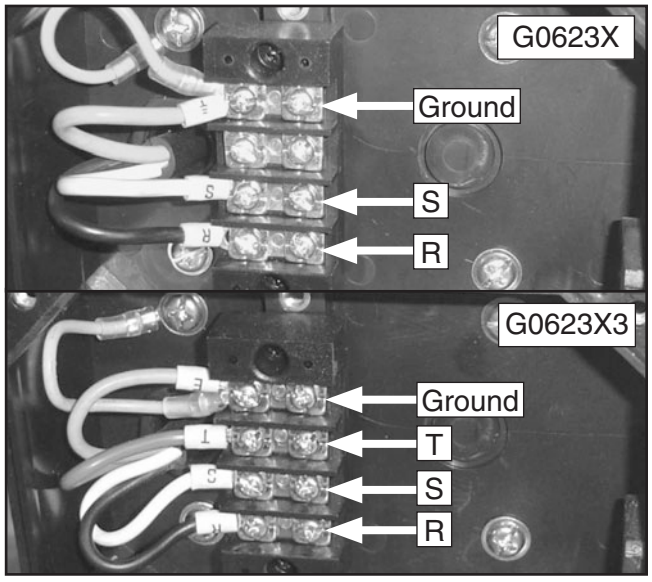


Figure 49. Main terminal boxes.

Test Run

After the machine has been connected to the power source, the machine MUST be test run to make sure all the controls and safety components function properly before the machine is placed into regular operation.

It is extremely important that all steps in this section be followed very closely, in the order given, to ensure that the safety features are tested correctly.

Before beginning the test run, review the power controls shown in **Figure 50** and **Controls & Features** on **Page 9**.

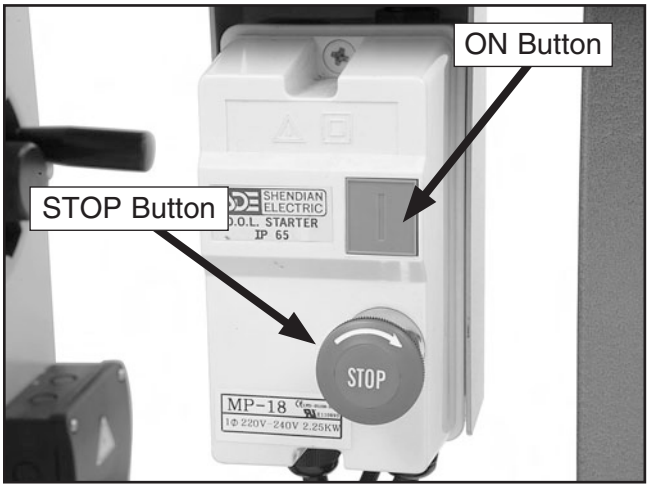


Figure 50. Main power controls.

⚠WARNING

If the machine does not operate as stated in this section, review the troubleshooting section on Page 49. If you need additional help, call Tech Support at (570) 546-9663. DO NOT place a machine into regular operation if you suspect that it is malfunctioning, or serious injury could occur.

To test run the saw:

1. Put on safety glasses, make sure any bystanders are out of the way, and that all tools have been removed from the saw.

2. Push in, then rotate both STOP buttons clockwise until they pop out. This resets the switch so the machine can be started.

3. Press the ON button. The blades should startup and run smoothly without any problems. *If any problems occur, immediately press the STOP button.*

4. Press the STOP button. As the main blade comes to a stop, watch the direction that it spins.

   —The main blade should spin clockwise if you are standing at the front of the machine. If this is true, continue to **Step 5**.

   —If the main blade rotates counterclockwise, disconnect the saw from power and exchange wires R & T in the power connection box to change the motor direction (Model G0623X3 only). After exchanging the wires and closing the power connection box, connect the saw to power, and repeat **Steps 3–4**.

5. Make sure the STOP button is pushed in, then press the ON button.

   —The saw should NOT start if the disabling feature on the STOP button is working correctly. If this is true, continue to **Step 6**.

   —If the saw DOES start when the STOP button is pushed in, then the safety feature on the STOP button is not working correctly. Call Tech Support for advice before proceeding any further with the test run or machine operations.

6. DISCONNECT SAW FROM POWER!

7. Move the sliding table all the way forward, then open the orange blade guard (refer to **Page 37** for details on accessing and opening the blade guard). Opening the blade guard triggers the limit switch.

8. Connect the saw to the power source and rotate the STOP button clockwise so it pops out.

9. (During this step, be prepared to immediately press the STOP button if the blades start operating.) Press the ON button.

   —If the blade guard limit switch functions correctly, the machine will not start. If this is true, continue to **Step 10**.

   —If the machine starts during this test, the limit switch is NOT functioning correctly. Disconnect the saw from power, and call Tech Support for advice before proceeding any further with the test run or machine operations.

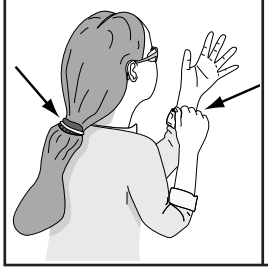
10. Close the orange blade guard and move the sliding table back to the center of the machine.

SECTION 4: OPERATIONS

Operation Safety

⚠WARNING

Damage to your eyes, lungs, and hearing could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.



⚠WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing and long hair away from moving machinery.

NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Sliding Table Saw Overview

A sliding table saw is primarily used to rip and crosscut sheet stock or panels in a production setting. The sliding table makes it much easier and safer to feed these large workpieces through a cut. This saw can also be used as a traditional table saw for most types of through-cuts.

The primary components of a sliding table saw are the sliding table, the fixed table, the crosscut table and fence, the rip fence, the main blade and the scoring blade.

A typical cut using the sliding table is made by placing the workpiece on the sliding table and crosscut table, positioning it against the crosscut fence where needed so the waste portion of the workpiece is on the opposite side of the blade, and pushing the workpiece through the blade by sliding the table.

The scoring blade may or may not be used, depending on if the workpiece is faced with laminate, melamine, or other solid surface material, or if tear-out free cuts are required. If the scoring blade is not needed for cutting operations, it can be lowered under the table so it will stay sharp for later operations.

When using the sliding table saw as a traditional table saw, the sliding table is locked in place and the rip fence is then used to guide the workpiece through the cut.

In order to produce accurate results, the sliding table must move parallel to the blade and the scoring blade must be aligned with the main blade. Similarly, the rip fence must be parallel with the main blade and the crosscut fence must calibrated to the main blade.

Safety Tips

Your safety is important. The tips below are intended to supplement **SECTION 1: SAFETY**. But remember, no safety list can cover every situation. The operator is ultimately responsible for their own safety, as well as the safety of bystanders. Every cutting operation is uniquely different and may require safety equipment or safety procedures not mentioned in this manual.

Please follow these safety tips EVERY time you use your saw:

- Stand to the left of the blade line-of-cut when performing a cutting operation.
- Turn ***OFF*** the saw and allow the blade to come to a complete stop before removing cut-off pieces.
- Make sure that the riving knife is always aligned with the main blade before cutting!
- Always position the blade guard to the correct height above the workpiece.
- Carefully plan each cutting operation to avoid injuries.
- When you release the sliding table lock, make sure that the knob is positioned so that it will not lock the table during a cut.
- Plan your cut to avoid putting your hands near the blade or reaching across the blade.

Workpiece Inspection

Some workpieces are not safe to cut or may require modification before they are safe to cut. **Before cutting, inspect all workpieces for the following:**

- ***Material Type:*** This machine is intended for cutting natural and man-made wood products, laminate covered wood products, and some plastics. Cutting drywall or cementitious backer board creates extremely fine dust and may reduce the life of the bearings. This machine is NOT designed to cut metal, glass, stone, tile, etc.; cutting these materials with a table saw may lead to injury.
- ***Foreign Objects:*** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While cutting, these objects can become dislodged and hit the operator, cause kickback, or break the blade, which might then fly apart. Always visually inspect your workpiece for these items. If they can't be removed, DO NOT cut the workpiece.
- ***Large/Loose Knots:*** Loose knots can become dislodged during the cutting operation. Large knots can cause kickback and machine damage. Choose workpieces that do not have large/loose knots or plan ahead to avoid cutting through them.
- ***Wet or "Green" Stock:*** Cutting wood with a moisture content over 20% causes unnecessary wear on the blades, increases the risk of kickback, and yields poor results.
- ***Excessive Warping:*** Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and often unpredictable when being cut. DO NOT use workpieces with these characteristics!
- ***Minor Warping:*** Workpieces with slight cupping can be safely supported if the cupped side is facing the table or the fence. On the contrary, a workpiece supported on the bowed side will rock during a cut and could cause kickback or severe injury.

Through Cuts

Through Cuts

A through cut is a sawing operation in which the workpiece is completely sawn through. Ripping, crosscutting, miter cuts, and angled cuts are all through cutting operations. The blade guard and splitter or riving knife must be installed during through cuts.

Through cuts have a risk of kickback. Read, understand, and follow instructions and safety precautions for each type of cut to reduce the risk of injury.

Safety precautions and instructions for each type of cut are located on the following pages:

- **Rip Cuts: Page 40**
- **Cross Cuts: Page 42**
- **Miter Cuts: Page 44**

Non-Through Cuts

Non-Through Cuts

A non-through cut is a sawing operation where the blade does not protrude above the top face of the wood stock. This machine is NOT designed to make non-through cuts. Dado cuts, rabbet cuts, and resawing operations are typical non-through table saw cuts.

Changing Main Blade

This saw performs best with high-quality sharp blades. Whenever the blades become dull, replace or sharpen them.

To change the main blade:

1. DISCONNECT SAW FROM POWER!

2. Move the blade tilt to 0° (blade 90° to table) and raise the main blade as far as it will go.

3. Move the sliding table all the way forward to expose the internal blade guard that covers the blades and riving knife, as shown in **Figure 51**.

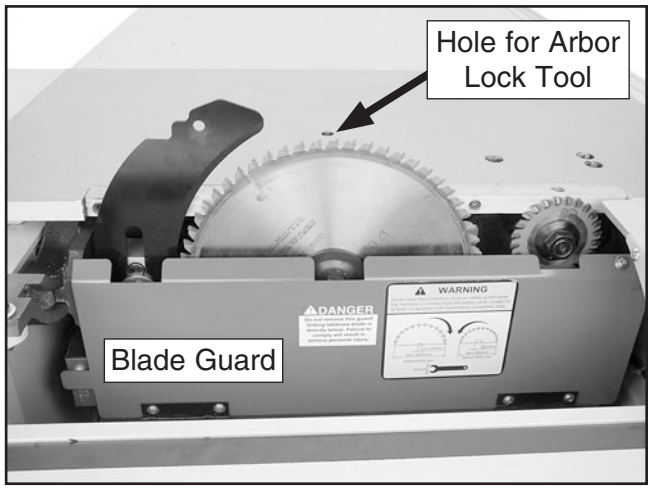


Figure 51. Internal blade guard exposed.

4. Pull the blade guard away from the blades to expose the mounting assembly. (The internal blade guard is held in place with a magnet.)

5. Insert the arbor lock tool into the hole shown in **Figure 51**, then rotate the blade by hand until the arbor lock tool seats.

⚠CAUTION

Before proceeding with the next steps, wear gloves to protect your hands when handling and installing the blade.

6. Use the arbor wrenches to remove the arbor nut and arbor flange, then pull the old blade off the arbor.

   Note: *The arbor nut has left hand threads and loosens by turning clockwise.*

7. Slide the new blade over the arbor with the teeth facing the right of the saw, as shown in **Figure 52**.

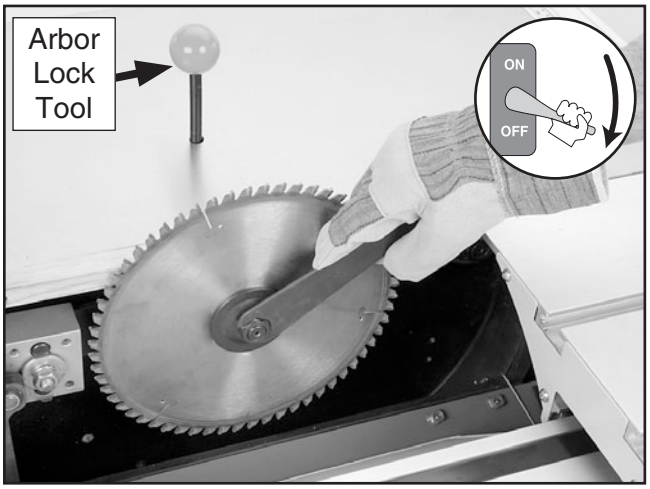


Figure 52. Replacing the main blade.

8. Re-install the arbor flange and the arbor nut, then tighten them against the blade as shown in **Figure 52**. There MUST be an arbor flange on both sides of the blade.

   — If you changed the diameter of the blade during this procedure, adjust the riving knife according to the instructions titled **Riving Knife Adjustment** on **Page 38**.

9. Move the orange blade guard back into its original position, next to the blades, and center the sliding table.

Riving Knife Adjustment

Whenever a new blade is installed, the position of the riving knife must be checked and adjusted if it is not aligned with the new blade or if becomes spaced too close or too far away from the new blade.

To adjust the riving knife:

1. DISCONNECT SAW FROM POWER!

2. Move the blade tilt to 0˚ (blade 90˚ to table), and raise the main blade as far as it will go.

3. Move the sliding table all the way forward and pull the blade guard open. (The blade guard is held in place with a magnet.)

4. Remove the upper blade guard.

5. Loosen the riving knife center bolt as shown in **Figure 53**.

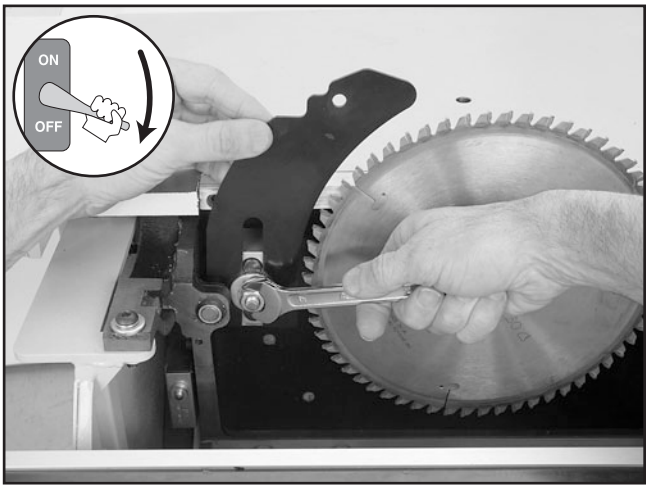


Figure 53. Re-adjusting the riving knife.

6. Position the riving knife about 3mm or ⅛" away from the nearest carbide tooth on the main blade.

   Note: *For a quick gauge, use the 3mm or ⅛" hex wrench to find the correct spacing between the blade and the riving knife, as shown in* ***Figure 54****.*

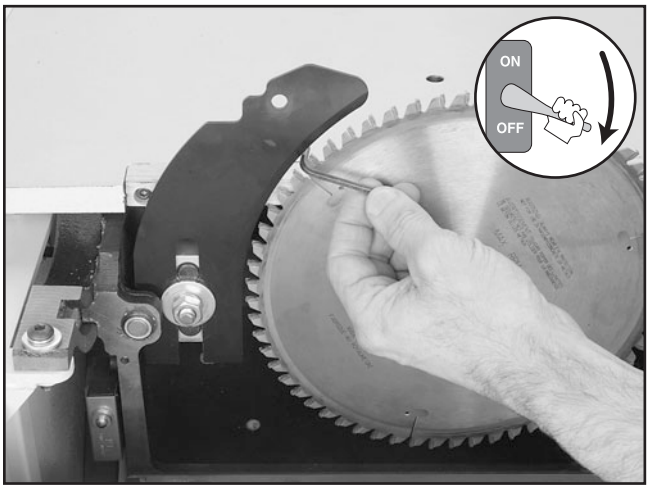


Figure 54. Aligning the riving knife.

7. Tighten the center bolt to secure the riving knife in position.

8. Re-install the upper blade guard, close the blade guard, and move the sliding table back to center.

Adjusting and Replacing Scoring Blade

The scoring blade included with the sliding table saw has wedge shaped teeth. The kerf thickness is adjusted by changing the height of the scoring blade.

To change the scoring blade:

1. DISCONNECT SAW FROM POWER!

2. Move the blade tilt to 0˚ (blade 90˚ to table), and raise the scoring blade all the way up.

3. Move the sliding table all the way forward and pull the interal blade guard open. (The internal blade guard is held in place with a magnet.)

4. Remove the upper blade guard.

5. To remove the scoring blade, insert the arbor lock tool in the table (**Figure 55**), rotate the scoring blade to seat the arbor lock tool, and use the arbor wrenches to remove the arbor nut and arbor flange. **Note:** *The arbor nut has right-hand threads and loosens by turning counterclockwise.*

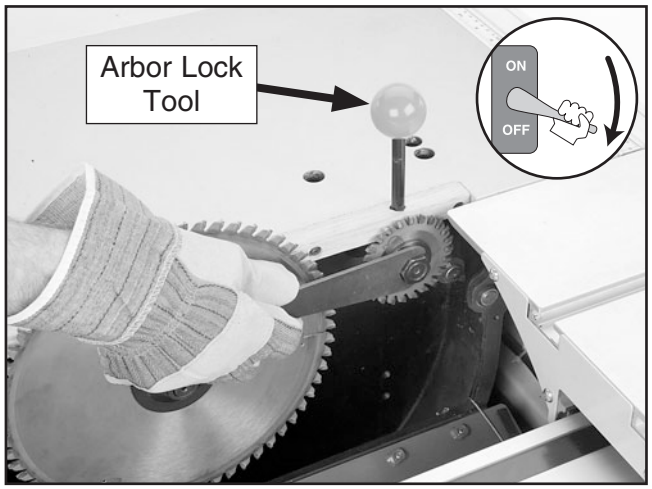


Figure 55. Removing the scoring blade.

6. Install the new scoring blade, re-install the arbor flange and the arbor nut, and tighten them against the blade set. There MUST be an arbor flange on both sides of the blade.

7. Unlock the scoring blade controls by inserting a 6mm hex wrench into the controls lock hole shown in **Figure 56** and turning the mechanism inside counterclockwise until loose.

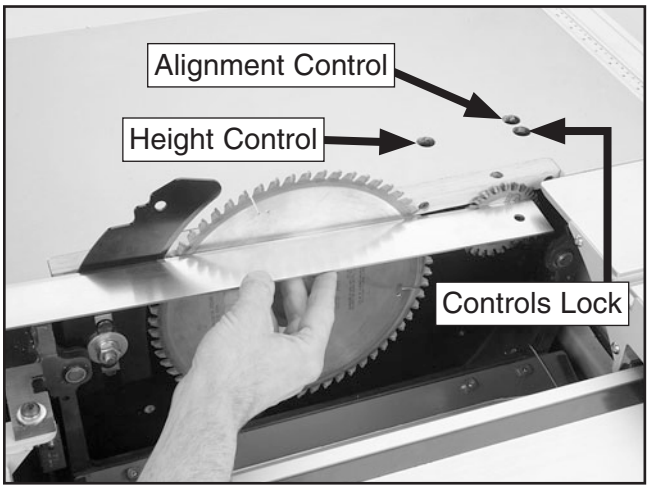


Figure 56. Checking and adjusting scoring blade positioning.

8. Adjust the height of the scoring blade until the exposed portion equals the kerf thickness of the main blade. The scoring blade height control is accessed through the hole in the table (**Figure 56**) and adjusts with a 6mm hex wrench.

   Note: *The easiest way to match the scoring blade kerf is by laying a straightedge on the table, and placing it up against the main blade teeth and beyond the scoring blade, then adjusting the scoring blade height until its teeth align with the main blade teeth. Also check on the other side of the blades to verify that the kerf thickness matches and the scoring blade is aligned with the main blade.*

9. If the scoring blade is not aligned with the main blade, adjust the blade alignment control (**Figure 56**), using a straightedge as a guide.

10. Tighten the controls lock.

11. Move the orange blade guard back into its original position, next to the blades, and center the sliding table.

12. Perform a test cut and check for chip out on the underside of the test piece. If there is chip out, make the adjustments necessary to match the kerfs.

Rip Cutting

This saw has the capability of rip cutting large panels (**Figure 57**). The sliding table removes the burden of sliding a large and heavy panel over a stationary table surface.

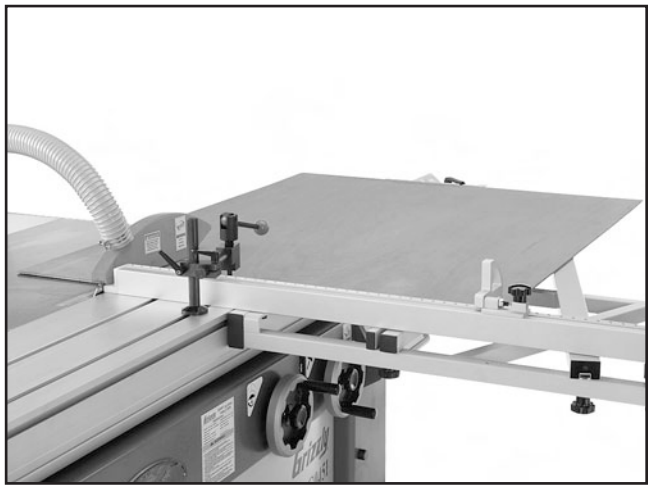


Figure 57. Rip cutting with the sliding table.

This saw also has the capability of rip cutting smaller boards, using the machine as a traditional table saw (**Figure 58**). Smaller, lighter boards are easier to slide across the stationary cast iron table surface to the right of the saw blade.

Figure 58. Traditional rip cutting.

Determine which cutting operation will be best suited for the workpiece to be ripped.

—To use the sliding table, read the instructions titled “Rip Cutting w/Sliding Table.”

—To use the machine as a traditional table saw, skip ahead to “Rip Cutting w/Rip Fence.”

Rip Cutting with Sliding Table

1. Install the crosscut fence on the crosscut table, and rotate it until the fence touches the 90° stop bolt (**Figure 59**).

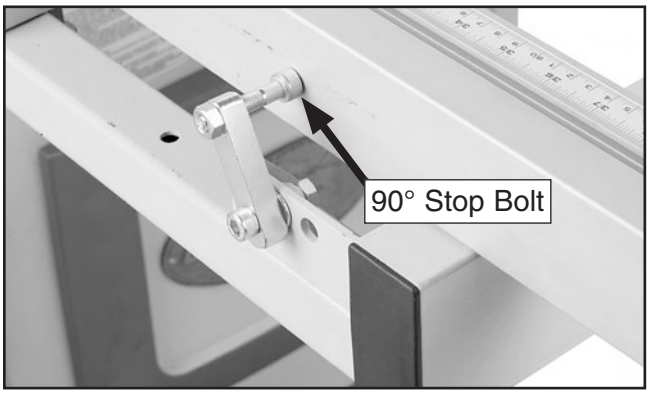


Figure 59. Crosscut fence mounting locations.

2. Check to make sure the fence is at 90˚ and, if necessary, adjust it as described in **Squaring Crosscut Fence to Blade** on **Page 55**.

3. Slide the fence so the plastic block on the end is next to the blade teeth—this calibrates the scale to zero—then tighten the lock knob.

   Note: *Avoid cutting the plastic block on the end of the fence.*

4. Set a flip stop to the desired width-of-cut.

5. Position the blade guard to the correct height for your workpiece.

6. Load the workpiece onto the table saw. The set up should look similar to **Figure 57**.

7. Take all the necessary safety precautions, then perform the cutting operation.

Rip Cutting with Rip Fence

1. Slide the crosscut table out of the way.

2. Lock the sliding table into a stationary position (see **Figure 60**).

   Note: *The table will only lock in place when it is centered with the saw cabinet.*

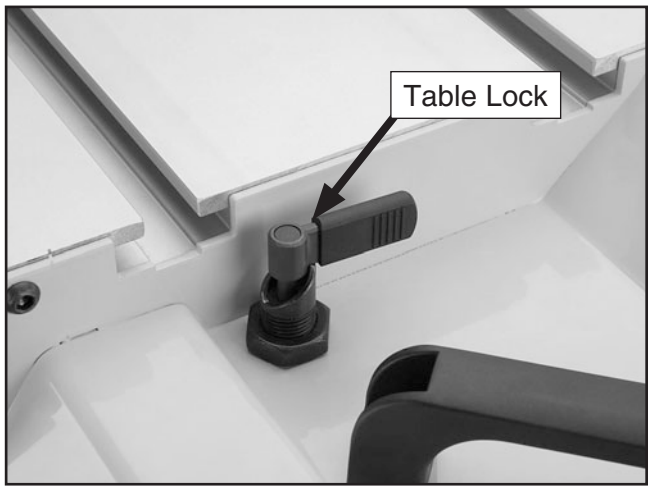


Figure 60. Sliding table lock.

3. Place the fence in the vertical position for larger workpieces, or in the horizontal position for angled cuts and for small workpieces (see **Figure 61**).

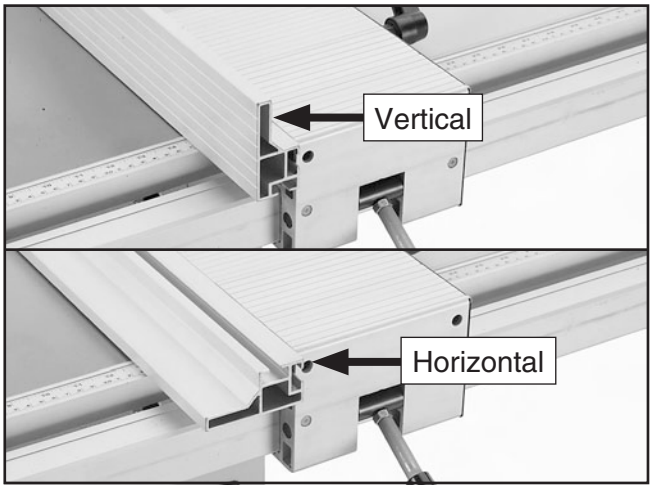


Figure 61. Rip fence positions.

4. Slide the leading end of the rip fence so it is even with the center of the main saw blade as shown in **Figure 62**.

   Note: *This technique allows the finished cut-off piece to "fall" away from the blade when the cutting operation is complete; reducing the possibility of kickback.*

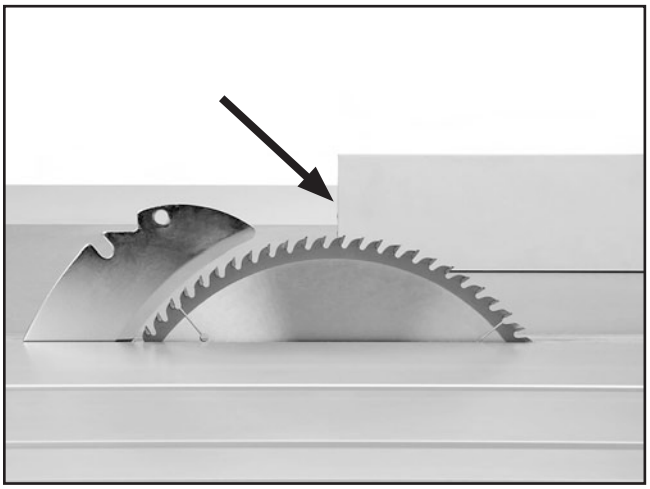


Figure 62. Rip fence even with center of blade (blade guard removed for clarity).

5. Tighten the lock handles (**Figure 63**) to secure the rip fence against the base.

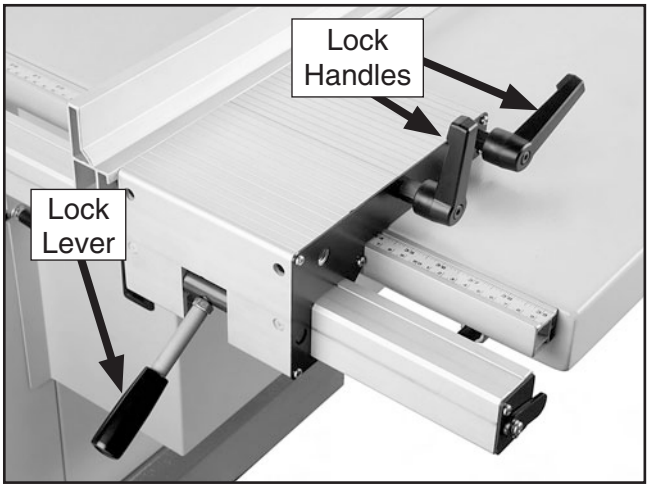


Figure 63. Rip fence micro-adjusting controls.

6. Pull up the lock lever to loosen the fence base on the rail, position the fence at the correct distance away from the blade (as needed for the cut), then push down the lock lever to lock the fence base in position.

7. Take all the necessary safety precautions, then make the cut as you would with a traditional table saw.

Crosscutting

The Model G0623X/G0623X3 can crosscut full size panels with the fence in the forward or rear position, although it is easier to load full size panels with the crosscut fence mounted in the forward position (see **Figure 64**).

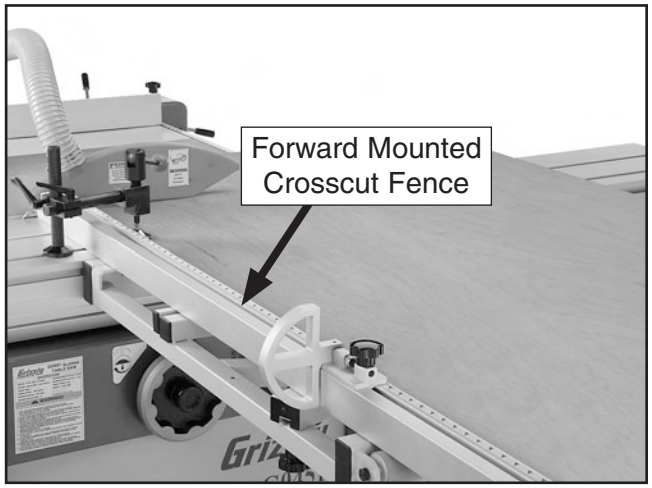


Figure 64. Crosscutting full size panel.

Mounting the crosscut fence in the rear position (**Figure 65**) gives greater stability for crosscutting smaller panels.

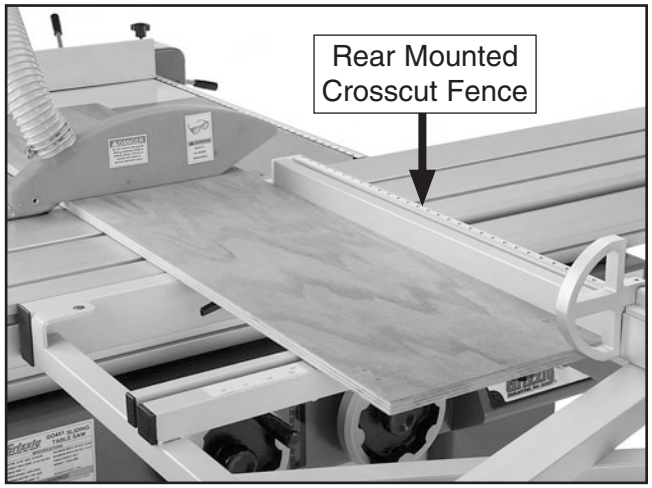


Figure 65. Crosscutting smaller panels.

Additionally, this machine has the capability of crosscutting workpieces while using the rip fence as a cut-off gauge (**Figure 66**).

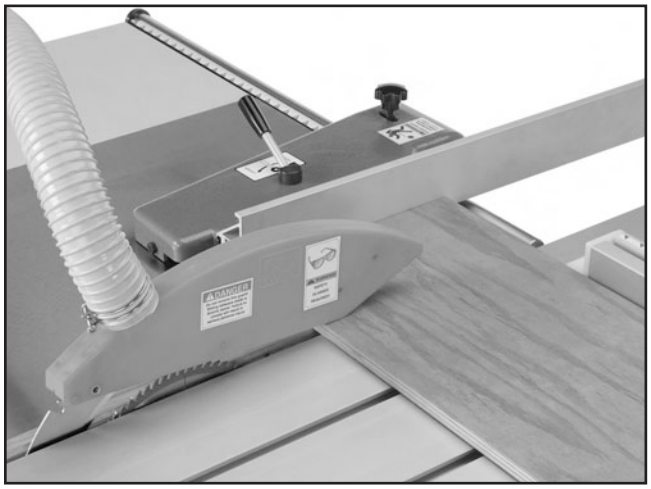


Figure 66. Crosscutting workpieces using the rip fence as a cut-off gauge.

Determine which cutting operation will be best suited for the workpiece to be crosscut.

—If you will be crosscutting full size panels, then skip ahead to **Crosscutting Full Size Panels**.

—If you will be crosscutting smaller panels, then skip ahead to **Crosscutting Smaller Panels**.

—If you will be crosscutting workpieces using the rip fence as a cut-off gauge, then skip ahead to **Crosscutting Using Rip Fence as a Cut-Off Gauge**.

Crosscutting Full Size Panels

1. Install the crosscut fence in the forward mounting location shown in **Figure 67** and lock it in place.

2. Check to make sure the fence is at 90˚ and adjust it as described in **Squaring Crosscut Fence to Blade** on **Page 55** if necessary.

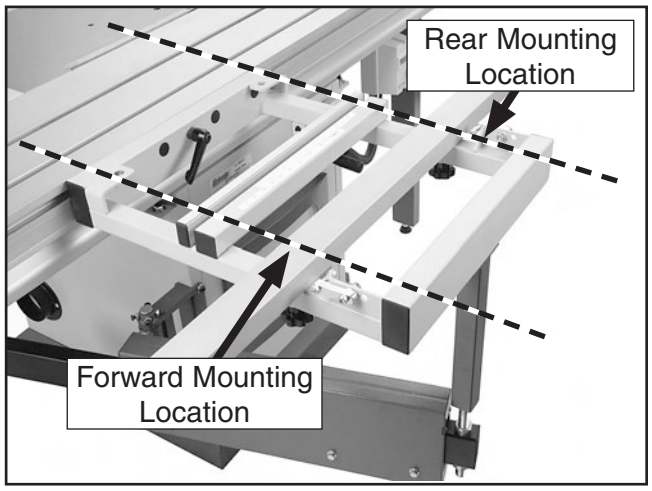


Figure 67. Crosscut fence mounting points.

3. Set either flip stop to the desired width-of-cut.

   Note: *Extend the crosscut fence slide if the workpiece is more than 74".*

4. Load the workpiece onto the table saw. The set up should look similar to **Figure 64**.

5. Once all the necessary safety precautions have been taken, perform the cutting operation.

Crosscutting Smaller Panels

1. Install the crosscut fence in the rear mounting points shown in **Figure 67** and lock it in place.

2. Check to make sure the fence is at 90˚ and adjust it as described in **Squaring Crosscut Fence to Blade** on **Page 55** if necessary.

3. Set either flip stop to the desired width-of-cut.

   Note: *Extend the crosscut fence slide if the workpiece is more than 74".*

4. Load the workpiece onto the table saw. The set up should look similar to **Figure 65**.

5. Once all the necessary safety precautions have been taken, perform the cutting operation.

Crosscutting Using Rip Fence as a Cut-Off Gauge

1. Install the crosscut fence in the rear mounting points shown in **Figure 67** and lock it in place.

2. Check to make sure the fence is at 90˚ and adjust it as described in **Squaring Crosscut Fence to Blade** on **Page 55** if necessary.

3. Position the rip fence for the desired width.

4. Load the workpiece onto the table saw. The setup should look similar to **Figure 66**.

5. Slide the leading end of the rip fence behind the front edge of the blade as shown in **Figure 68**. **(This step is critical to reduce the risk of blade binding and kickback.)**

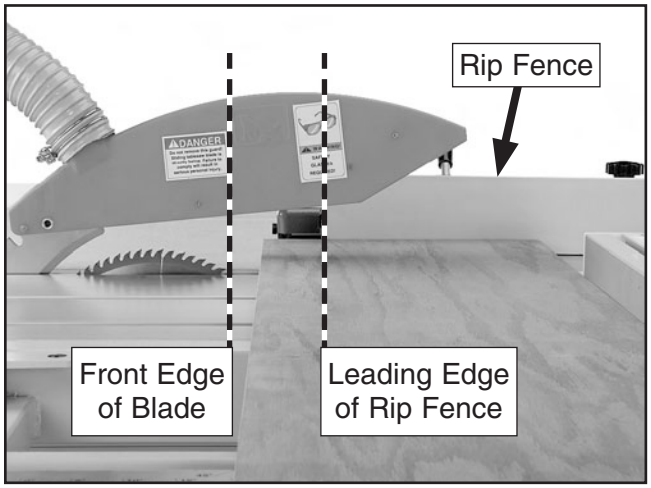


Figure 68. Correct rip fence position when using it as a cut-off gauge.

6. Take all the necessary safety precautions, then perform the cutting operation.

Miter Cutting

The crosscut fence allows miter cuts from 0˚ through 135˚. The table mounted miter scale has a resolution of 1˚.

To perform a miter cut:

1. Slide the crosscut table to the front edge of the sliding table and lock it in place.

2. Place the crosscut fence center stud in the left or right stud hole of the crosscut table. The fence can be installed as shown in **Figure 69** for 90˚ to 135˚ cuts, or as shown in **Figure 70** for 0˚ to 90˚ cuts.

Figure 69. Fence set-up for 90˚ to 135˚ cuts.

3. Rotate the fence to the desired angle and lock it in place.

4. Position the flip stop according to the length of the workpiece you want to cut off to the left of the blade.

5. Load the workpiece onto the table saw. The set up should look similar to **Figure 70**.

Figure 70. Example of miter cutting operation.

6. Once all the necessary safety precautions have been taken, perform the cutting operation.

SECTION 5: ACCESSORIES

T20501—Face Shield, 4" Crown, Clear
T20502—Face Shield, 7" Crown, Clear
T20448—Economy Clear Safety Glasses
T20452—"Kirova" Anti-Reflective Glasses
T20456—"Dakura" Clear Safety Glasses
H0736—Shop Fox® Safety Glasses
These glasses meet ANSI Z87.1-2003 specifications. Buy extras for visitors or employees. You can't be too careful with shop safety!

Figure 71. Our most popular eye protection.

T20514—Small Half-Mask Respirator
T20515—Medium Half-Mask Respirator
T20516—Large Half-Mask Respirator
T20511—Pre-Filter P100
T20539—Cartridge Filter 2PK P100
T20541—Cartridge Filter 2PK P100 & O Vapor
Wood and other types of dust can cause severe respiratory damage. If you work around dust everyday, a half-mask respirator can greatly reduce your risk. Compatible with safety glasses!

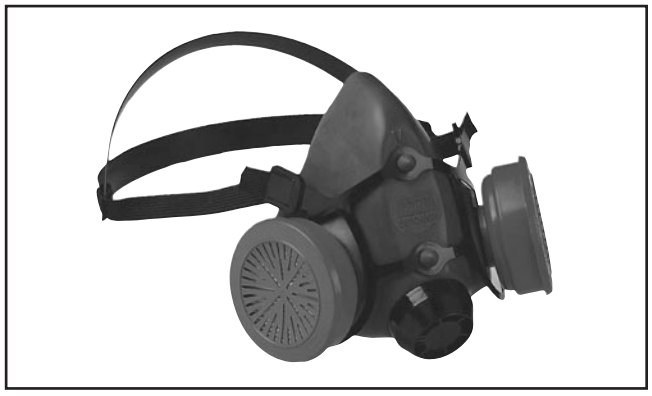


Figure 72. Half-mask respirator with disposable cartridge filters.

Recommended 10" Blades

H5190—Razor Variable Tooth Carbide, 50T
H9146—Heavy-Duty ATB Carbide Tip, 60T
G2804—Commercial Solid Surface Blade, 60T
H9147—Heavy-Duty ATB Carbide Tip, 80T
H9360—Commercial Melamine Blade, 80T
H9148—Heavy-Duty ATB Carbide Tip, 100T
These blades work especially well for most sliding table saw applications and are manufactured for heavy-duty, industrial use.

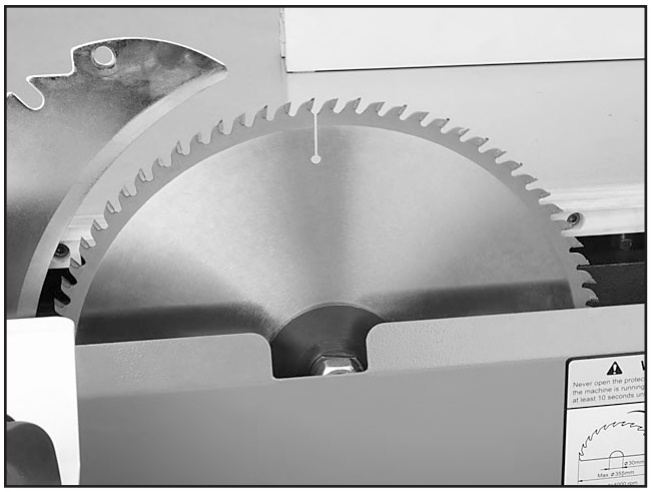


Figure 73. Carbide-tipped saw blade.

H4935—Stackable Scoring Blade Set
The scoring blade set consists of an inner and outer blade and four internal shims. Two shims are 0.008" thick and two are 0.004". The shims are provided so the scoring blade set can match the kerf thickness of the main blade.

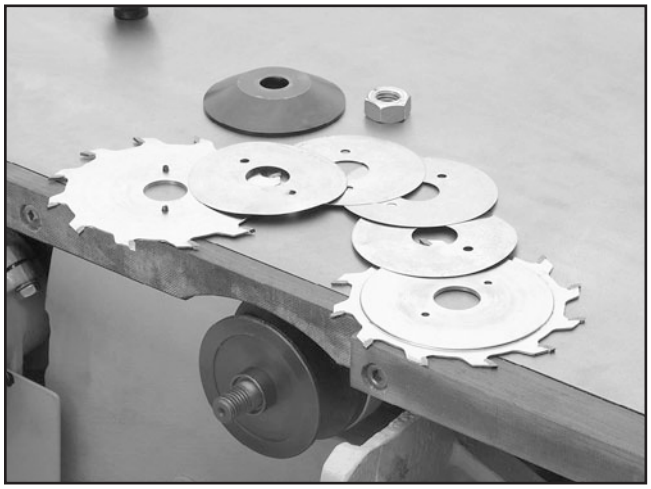


Figure 74. H4935 Scoring Blade Set.

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 12 oz Spray
G2871—Boeshield® T-9 12 oz Spray
G2870—Boeshield® T-9 4 oz Spray
H3788—G96® Gun Treatment 12 oz Spray
H3789—G96® Gun Treatment 4.5 oz Spray

Figure 75. Recommended products for protecting unpainted cast iron/steel part on machinery.

H7544—Material Cart
Built for moving sheet goods and long lumber, this material cart has outrigger mounted casters for maximum stability. Also features 5" casters with rear brakes. Very popular and affordable!

Figure 76. Model H7544 Material Cart.

Call 1-800-523-4777 To Order

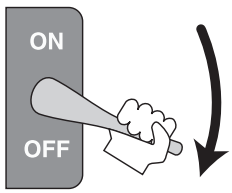
H6293—Hydraulic Lift Pallet Jack - 1,000 lbs.
H6294—Hydraulic Lift Pallet Jack - 2,000 lbs.
Perfect for moving pallets of sheet goods around the shop, and even better, raising them to table height so you can slide a sheet right off the pallet and onto the table saw without lifting. Maximum hoisting height is 59", forks are 31½" long, and fork width is adjustable to 37⅜" on Model H6294 and 29⅜" on Model H6293. A real backsaver and much less costly than a forklift!

Figure 77. Model H6294 Hydraulic Lift.

H8003—Hydraulic Lifting Table - 450 lbs.
This rugged and affordable lifting table allows you to lift stacks of sheet goods right up to the table saw table with minimal effort. Features 39⅜" x 19¾" table, 39½" maximum table height, 8" fixed and swivel casters with brakes.

Figure 78. Model H8003 Hydraulic Lifting Table.

SECTION 6: MAINTENANCE



⚠WARNING
Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.

Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Check:
- Loose mounting bolts.
- Worn or damaged saw blades.
- Worn or damaged switches or wires.
- Any other unsafe condition.

Weekly Maintenance:
- Clean sliding table surface and grooves.
- Clean the cast iron saw table.
- Clean the sliding table roller guideways.
- Clean the rip fence and sliding grooves.
- Clean the rip fence bracket.

Monthly Check:
- Clean/vacuum dust buildup from inside cabinet and off motor.
- V-belt tension, damage, or wear.

Note: *To ensure optimum power transmission from the motor to the blades, the V-belts must be in good condition (free from cracks, fraying and wear) and operate under proper tension.*

Cleaning

Cleaning the Model G0623X/G0623X3 is relatively easy. Vacuum excess wood chips and sawdust from the table saw and inside the cabinet. Wipe off the remaining dust with a dry cloth.

Use compressed air (make sure to wear safety glasses and a respirator when doing this) to blow dust from between the two sections of the sliding table. If any resin has built up, use a resin dissolving cleaner to remove it. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.

Unpainted Cast Iron

Protect the unpainted cast iron surfaces on the table by wiping the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. DO NOT clean cast iron with water or it will rust!

Keep tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Page 46** for more details).

Lubrication

Bearings: The bearings are sealed and pre-lubricated and require no lubrication.

Trunnions: Use multi-purpose grease in the trunnion grooves (**Figure 80**) every 6–12 months, depending on the frequency of use. To grease the blade height trunnion, move the blade height all the way down and smear a dab of grease into the trunnion groove, behind the plate shown in **Figure 80**, then move the blade up all the way to spread the grease.

To grease the blade tilt trunnions, move the sliding table out of the way and open the blade guard. Tilt the blade to 90°. From the front of the saw, smear a dab of grease in the front of the trunnion grooves on both sides. Now, tilt the blade to 45° and reach inside the cabinet and smear a dab of grease into the back of the trunnion grooves on both sides. Tilt the blade back-and-forth to distribute the grease evenly.

Leadscrews: Use multi-purpose grease on the leadscrews (**Figure 80**) every 6-12 months, at the same time you lubricate the trunnions. Wipe the leadscrews clean with a dry rag and brush a light coat of new grease on them with a clean, dry brush. Only grease the area of the leadscrew between the stop nuts. Move the blade height and tilt back-and-forth to distribute the grease evenly.

Sliding Table Ways: Spray/wipe on a light machine oil (such as Boeshield shown on **Page 46**) down the entire length of the steel rods (**Figure 79**).

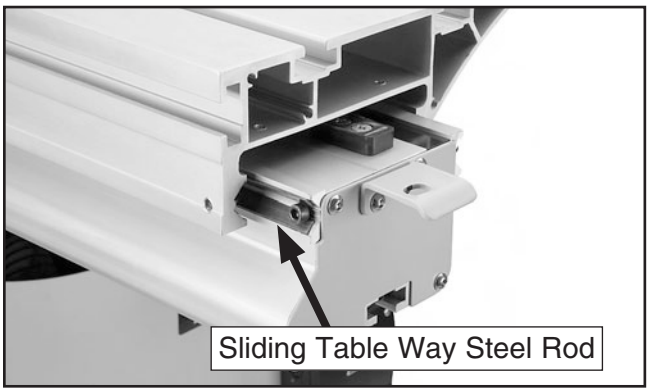


Figure 79. Sliding table ways.

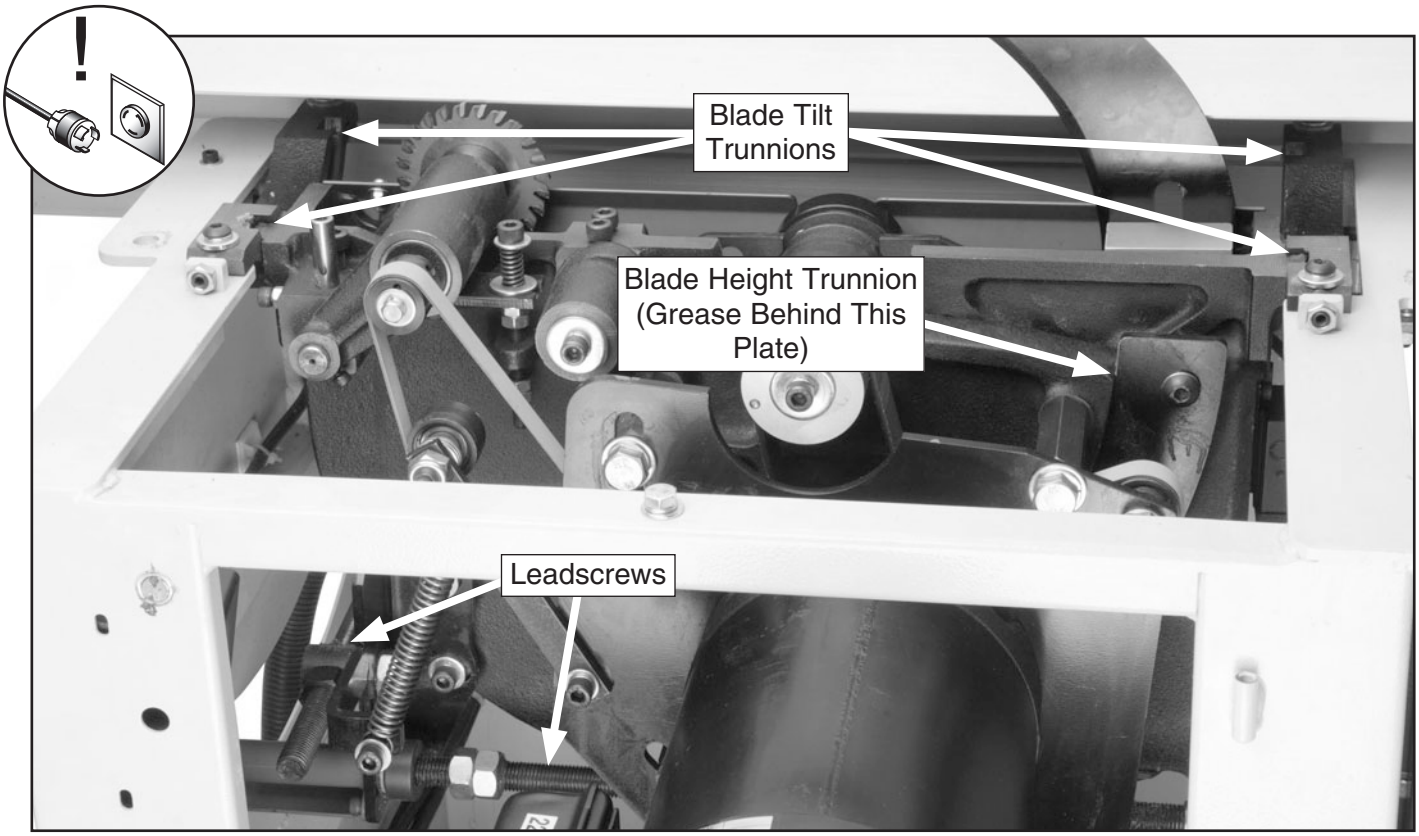
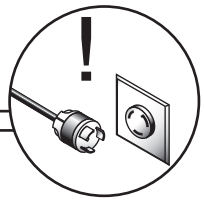


Figure 80. Lubrication locations (table removed for clarity).

SECTION 7: SERVICE

Review the troubleshooting and procedures in this section to fix or adjust your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	1. Emergency stop push-button is engaged/faulty.	1. Rotate clockwise slightly until it pops out/replace it.
	2. Power supply switched OFF or is at fault.	2. Ensure power supply is switch on; ensure power supply has the correct voltage.
	3. Blade guard limit switch engaged/at fault.	3. Move blade guard to the working position; replace faulty limit switch.
	4. Motor connection wired incorrectly.	4. Correct motor wiring connections.
	5. Thermal overload relay has tripped.	5. Turn cut-out dial to increase working amps and push the reset pin. Replace if tripped multiple times (weak relay).
	6. Wall fuse/circuit breaker is blown/tripped.	6. Ensure circuit size is suitable for this machine; replace weak breaker.
	7. Contactor not getting energized/has burnt contacts.	7. Test for power on all legs and contactor operation. Replace unit if faulty.
	8. Wiring is open/has high resistance.	8. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary.
	9. Motor ON button or ON/OFF switch is at fault.	9. Replace faulty ON button or ON/OFF switch.
	10. Start delay module is at fault.	10. Adjust to correct delay; replace module.
	11. Motor is at fault.	11. Test/repair/replace.
Machine stalls or is underpowered.	1. Feed rate/cutting speed too fast for task.	1. Decrease feed rate/cutting speed.
	2. Workpiece material is not suitable for this machine.	2. Only cut wood products; make sure moisture content is below 20% and there are no foreign materials in the workpiece.
	3. Belt(s) slipping.	3. Replace bad belt(s), align pulleys, and re-tension.
	4. Motor connection is wired incorrectly.	4. Correct motor wiring connections.
	5. Motor bearings are at fault.	5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
	6. Start delay module is at fault.	6. Adjust to correct delay; replace module.
	7. Motor is at fault.	7. Test/repair/replace.

Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation.	1. Motor or component is loose. 2. Blade is at fault. 3. Belt(s) worn or loose. 4. Pulley is loose. 5. Motor mount loose/broken. 6. Machine is incorrectly mounted or sits unevenly. 7. Arbor pulley is loose. 8. Motor fan is rubbing on fan cover. 9. Arbor bearings are at fault. 10. Motor bearings are at fault.	1. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid. 2. Replace warped, bent, or twisted blade; resharpen dull blade. 3. Inspect/replace belts (refer to **Page 51**). 4. Realign/replace shaft, pulley, setscrew, and key as required. 5. Tighten/replace. 6. Tighten/replace anchor studs in floor; relocate/shim machine. 7. Retighten/replace arbor pulley with shaft and thread locking liquid. 8. Replace dented fan cover; replace loose/damaged fan. 9. Replace arbor housing bearings; replace arbor. 10. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
Main blade runs backwards.	1. Two of the power wires are reversed (3-phase version only).	1. Exchange wires R & T in the terminal box (3-phase version only).

Operation

Symptom	Possible Cause	Possible Solution
Workpiece has burned edges, binds, or kicks back.	1. Sliding table is not parallel to blade. 2. Riving knife is not aligned with the blade. 3. Blade is warped.	1. Make sliding table parallel to the blade (**Page 53**). 2. Shim the riving knife to align it with the main blade. 3. Replace the blade.
Workpiece has chip out on the bottom edge.	1. Scoring blade height is incorrect. 2. Scoring blade is not aligned with the main blade. 3. Scoring blade kerf does not match the main blade.	1. Adjust the height of the scoring blade. 2. Align the scoring blade (**Page 39**). 3. Adjust the scoring blade kerf (**Page 39**).
Sliding table saw does not cut square.	1. Sliding table is not parallel to blade. 2. Rip fence is not parallel to blade. 3. Crosscut fence is not perpendicular to the blade.	1. Adjust the sliding table (**Page 53**). 2. Adjust the rip fence parallel to blade. 3. Adjust the crosscut fence perpendicular to the blade (**Page 55**).
Fence hits table top when sliding across table.	1. Front rail is too low. 2. Rip fence roller is too low.	1. Raise the front rail. 2. Adjust the rip fence roller.
Blade does not reach 90˚, or blade does not reach 45˚.	2. Blade stop bolts are out of adjustment.	2. Adjust the stop bolts (**Page 52**).
The rip fence scale is not accurate.	1. The rip fence scale is out of calibration or was not set up correctly.	1. Adjust the rip fence scale.
Handwheels for blade adjustments will not turn or are difficult to turn.	1. Shipping braces still attached. 2. Lock knob is tight. 3. Gears caked with dust.	1. Remove shipping braces. 2. Release the lock knob. 3. Clean out dust and grease the gears.

Belt Replacement

Main Belt Replacement

1. DISCONNECT SAW FROM POWER!

2. Tilt the blade to 45˚ and lower it as far as it will go.

3. Remove the motor cabinet door.

4. Loosen the pivot bolt and two adjustment bolts (**Figure 81**).

   Note: *DO NOT loosen these bolts more than ½" or you run the risk of the motor mount bolts coming out of their holes, which will be difficult to thread back in.*

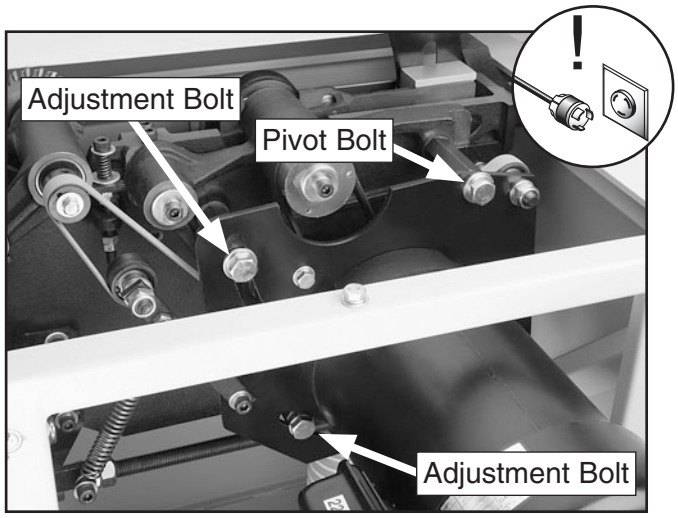


Figure 81. Main blade belt tension controls.

5. Push and hold the motor all the way up to relieve tension on the belt, remove the bels from the top pulley, and squeeze them between the lower pulley and casting.

6. Fit the new belts onto the pulleys in the same manner that you removed the old belts.

7. Push down on the motor with one hand, and tighten the adjustment and pivot bolts with the other hand or have someone help you. The belts should be tight enough that they only deflect approximately ¼" when pushed in the center with your thumb or index finger.

8. Replace the motor cabinet door.

Scoring Belt Replacement

1. DISCONNECT SAW FROM POWER!

2. Tilt the blade to 45˚ and lower it as far as it will go.

3. Remove the motor cabinet door.

4. Pull the tensioner away from the scoring belt (**Figure 82**) to relieve belt tension and remove the scoring belt from the pulleys.

   Note: *Turn the belt sideways to squeeze the flat part through the small gap between the bottom pulley and the casting.*

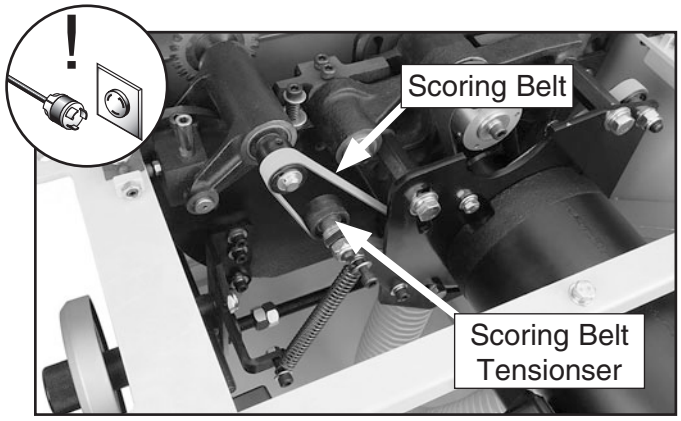


Figure 82. Replacing the scoring motor belt.

5. Put the new scoring belt on the pulleys as shown in **Figure 83**, and push the tensioner against the scoring belt to take up any slack.

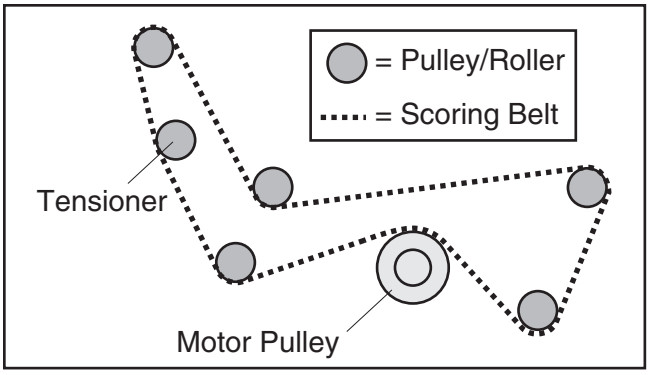


Figure 83. Scoring belt installation configuration.

6. Replace the motor cabinet door.

Blade Tilt Calibration

The blade tilt is calibrated at the factory, but can be recalibrated if it changes during the life of the machine. The 0° stop positions the blade square with the table.

0° Stop

1. DISCONNECT SAW FROM POWER!

2. Move the blade tilt to 0° according to the gauge, and raise the main blade as far as it will go.

3. Use a machinist's square to check if the blade is square to the table.

   —If the blade is not square to the table, loosen the two set screws that secure the 0˚ tilt stop nut shown in **Figure 84.**

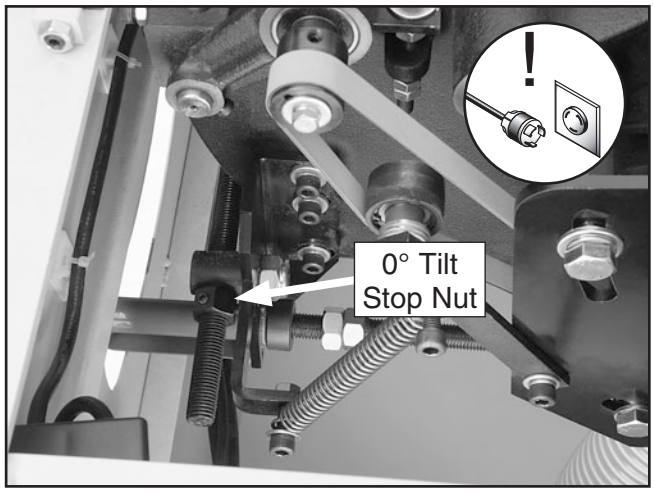


Figure 84. Blade tilt stop nut (0°).

4. Adjust the stop nut and recheck the blade tilt as many times as necessary until the blade is square to the table.

5. Tighten the two set screws in the stop nut.

6. Check the blade tilt pointer mechanism to ensure that it points to 0°.

   —If the blade tilt pointer shows an incorrect tilt, adjust it by loosening the cap screws, rotating the pointer until it points to 0°, then tightening the cap screws.

45° Stop

1. DISCONNECT SAW FROM POWER!

2. Adjust the blade angle until you hit the 45° positive stop and check the blade angle with a 45° square.

   —If the blade is not 45° to the table, loosen the two set screws that secure the 45˚ tilt stop nut shown in **Figure 85.** (This nut can also be accessed from the front of the saw by moving the sliding table all the way forward.)

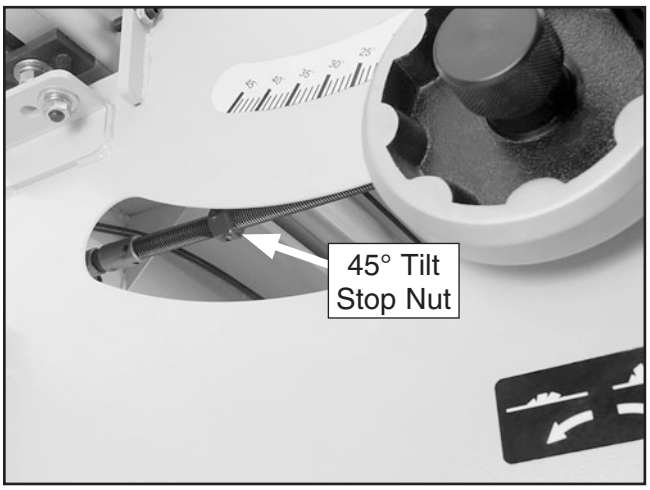


Figure 85. 45° Blade tilt stop nut.

3. Adjust the stop nut and recheck the blade tilt as many times as necessary until the blade is 45° to the table.

4. Tighten the two set screws in the stop nut.

Sliding Table Parallel Adjustment

The table is calibrated at the factory, but can be adjusted slightly if it is not parallel to the blade.

Besides the tools included with the saw, this procedure requires a felt tip pen, an adjustable square, and a set of feeler gauges or a dial indicator.

Note: *Using a dial indicator will provide much more accurate results.*

To adjust the sliding table parallel with the main blade:

1. DISCONNECT SAW FROM POWER!

2. Move the blade tilt to 0˚ (blade 90˚ to table), and raise the main blade up to maximum height.

3. Mark the edge of the blade with a felt tip pen. This will allow you to take your measurements from the exact same place on the blade.

4. Using an adjustable square or a dial indicator, measure the distance (A) between the miter slot and the front of the blade, as shown in **Figure 86**.

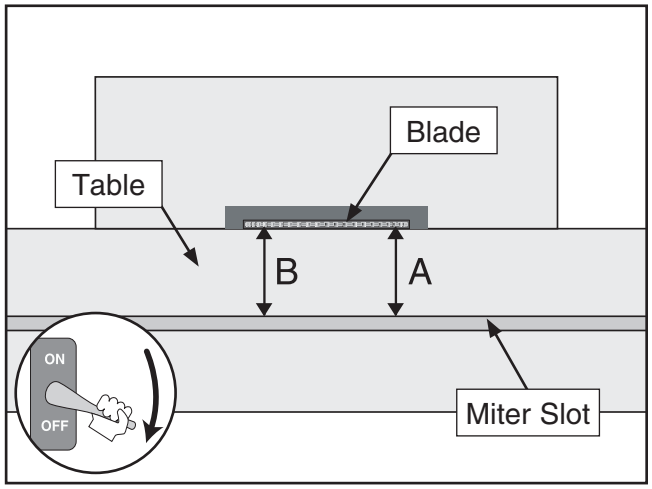


Figure 86. Measuring gap between the table and the blade.

5. Rotate the blade 180° and slide the table with the measuring device to position B.

6. Measure the difference between the two positions (use the feeler gauge if using the adjustable square). Make note of the difference between the two measurements.

   —If the gap is the same on both sides or the difference is 0.004" or less, no adjustments to the table parallelism need to be made.

   —If the difference is greater than 0.004", then the sliding table parallelism must be adjusted. Proceed to **Step 7**.

7. Loosen the sliding table mounting nuts (see **Figure 87**) at both mounting locations.

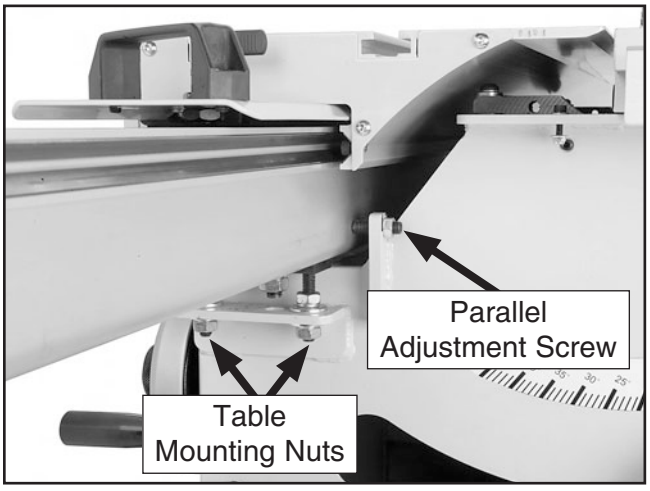


Figure 87. Table parallelism adjustment controls.

8. At the side of the table that needs to move, loosen the hex nut on the parallel adjustment screw.

9. Slowly rotate the parallel adjustment screw (see **Figure 87**) as necessary to move the table. If you move the adjustment screw away from the table, then push the table against the screw before proceeding.

10. Tighten the hex nut on the parallel adjustment screw to secure it in place, and tighten the table mounting nuts.

11. Repeat **Steps 4–6.**

NOTICE

If the sliding table will not move far enough to become parallel, the blade trunnions need to be shifted. Call Tech Support.

Sliding Table Adjustment

The sliding table features an adjustment bar with bolts that control how easily the sliding table moves across the base (see **Figure 88**). These adjustment bolts are factory set. They can only be accessed by removing the end covers from both ends of the sliding table base and sliding the plastic plate out of the way.

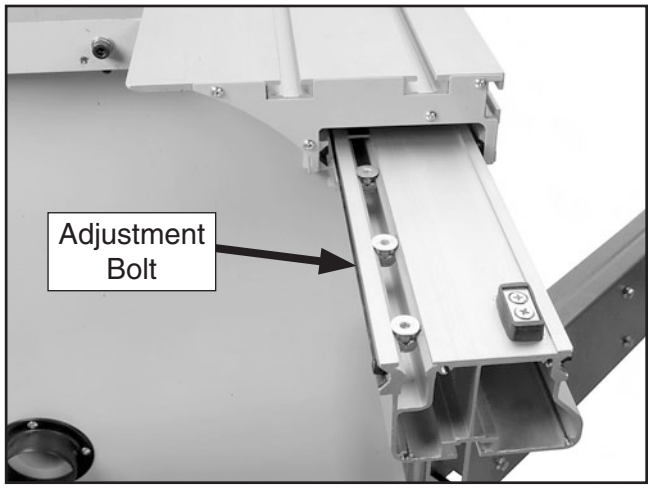


Figure 88. Adjustment bolt access location.

If the adjustment bolts do require adjustments, turning them counterclockwise increases pressure against the steel rails. This reduces table movement slop, which increases accuracy, but makes it harder to slide the table.

Turning the adjustment bolts clockwise decreases the pressure against the steel rails. This increases table movement slop, which reduces accuracy, but makes it easier to slide the table.

Adjusting this part of the sliding table correctly is a matter of trial-and-error by making adjustments, moving the sliding table, then making additional adjustments. Ultimately, the table must move easily without any slop.

Squaring Crosscut Fence to Blade

Squaring the crosscut fence to the blade ensures that cuts made with the crosscut fence will be square. This procedure can be done by using a piece of scrap plywood as a test piece and making five test cuts, then adjusting the fence as necessary.

To square the crosscut fence with the blade:

1. Make sure the blade is parallel with the sliding table and that the crosscut fence is resting against the 90° stop bolt (see **Figure 90** for locations).

2. Prepare the scrap test piece by cutting it to 32" x 32", then number all four sides of the test piece.

3. Use the crosscut fence to cut ½" off of each side of the test piece, then cut side 1 again (make five cuts total).

4. Measure the test piece diagonally from corner-to-corner as shown in **Figure 89**.

   —If both measurements are not within 1/16", then the crosscut fence needs to be adjusted. Proceed to **Steps 5–8**.

   —If both measurements are within 1/16" then no adjustments need to be made. You are finished with this procedure.

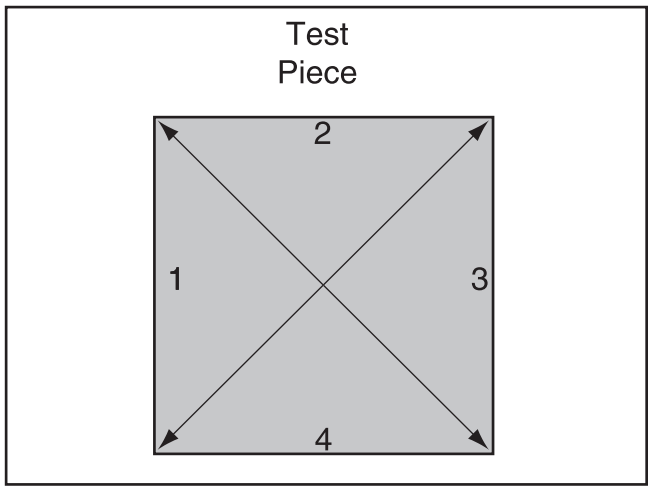


Figure 89. Fence adjustment test piece.

5. Loosen the knob on the crosscut fence to allow it to pivot (make sure 90° stop bolt remains against the fence during adjustments).

6. Loosen the hex nut on the 90° stop bolt shown in **Figure 90**, and rotate the 90° stop bolt to square the crosscut fence.

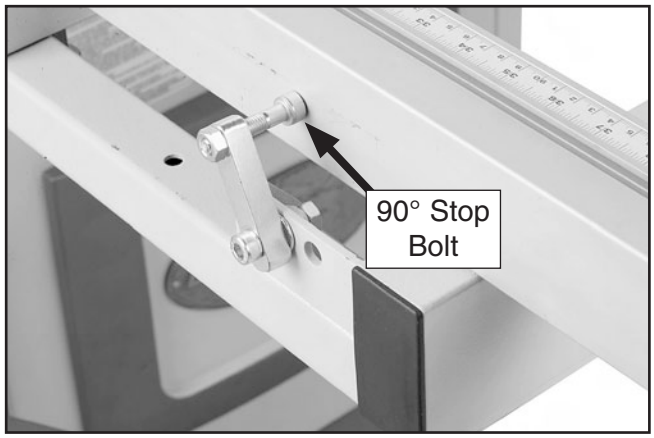


Figure 90. Crosscut fence adjustment cam.

7. Tighten the hex nut on the 90° stop bolt, then tighten the crosscut fence knob, making sure the block is touching the 90° stop bolt.

8. Repeat **Steps 3-4**.

G0623X Wiring Diagram

(for Machines Made before March, 2008)

Grizzly Industrial, Inc.®

COLOR KEY

BLACK — Bk

WHITE — Wt

GREEN — Gn

MAGNETIC SWITCH ASSEMBLY

EMERGENCY STOP SWITCH

BLADE GUARD LIMIT SWITCH

MOTOR 5HP 220V SINGLE-PHASE

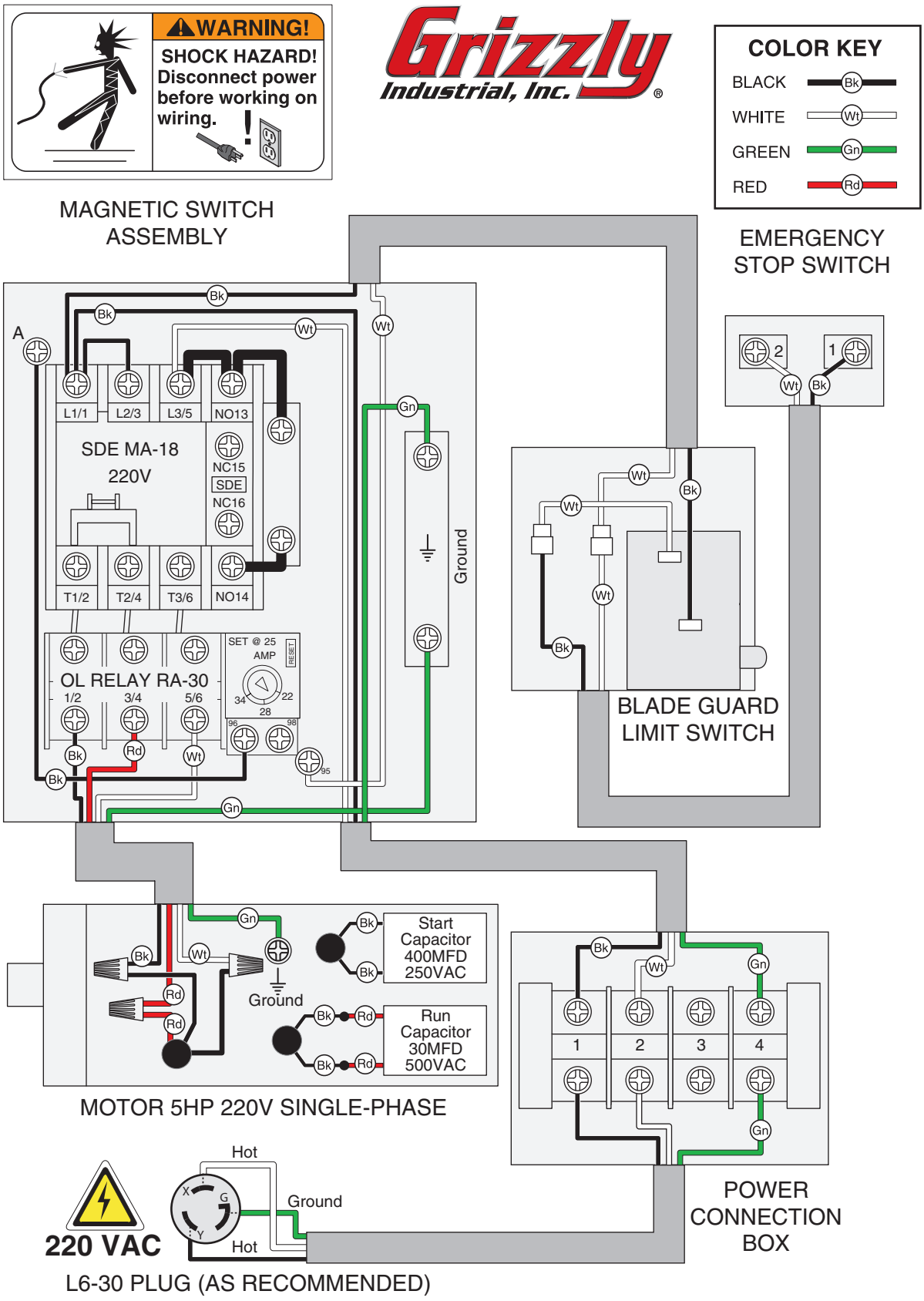
POWER CONNECTION BOX

220 VAC

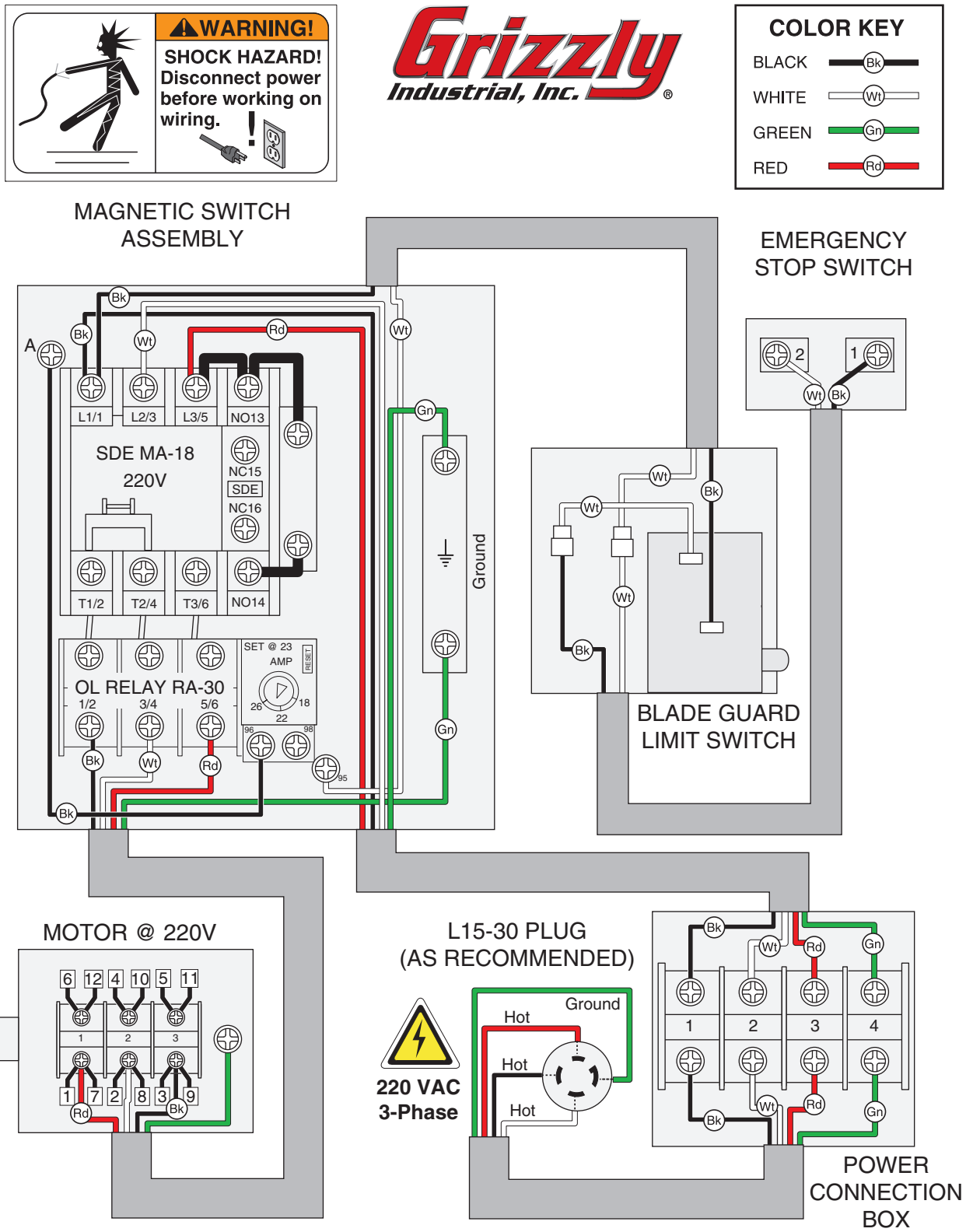
L6-30 PLUG (AS RECOMMENDED)

G0623X Wiring Diagram

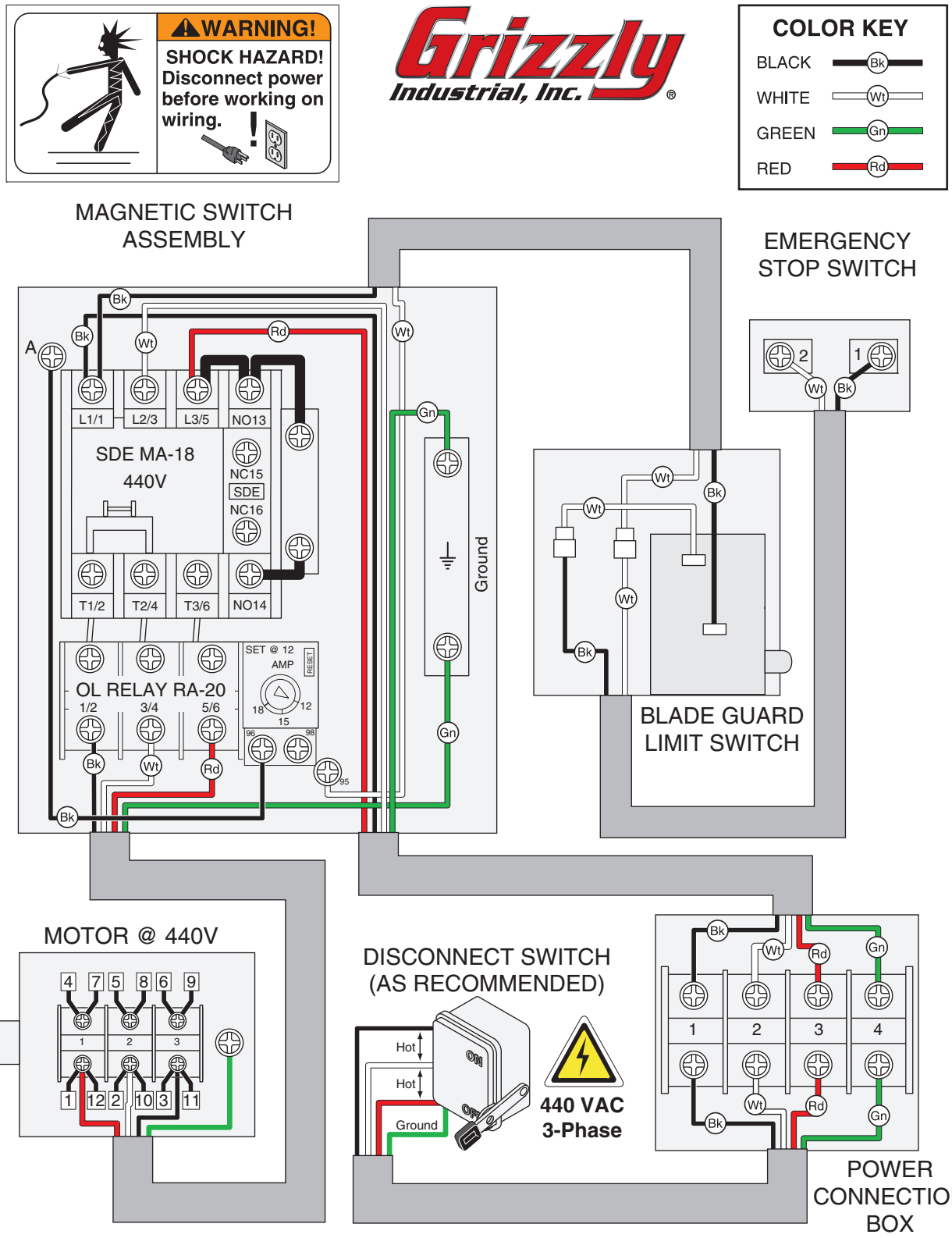
(for Machines Made in March, 2008 and later)



G0623X3 7.5 HP 220V Wiring Diagram

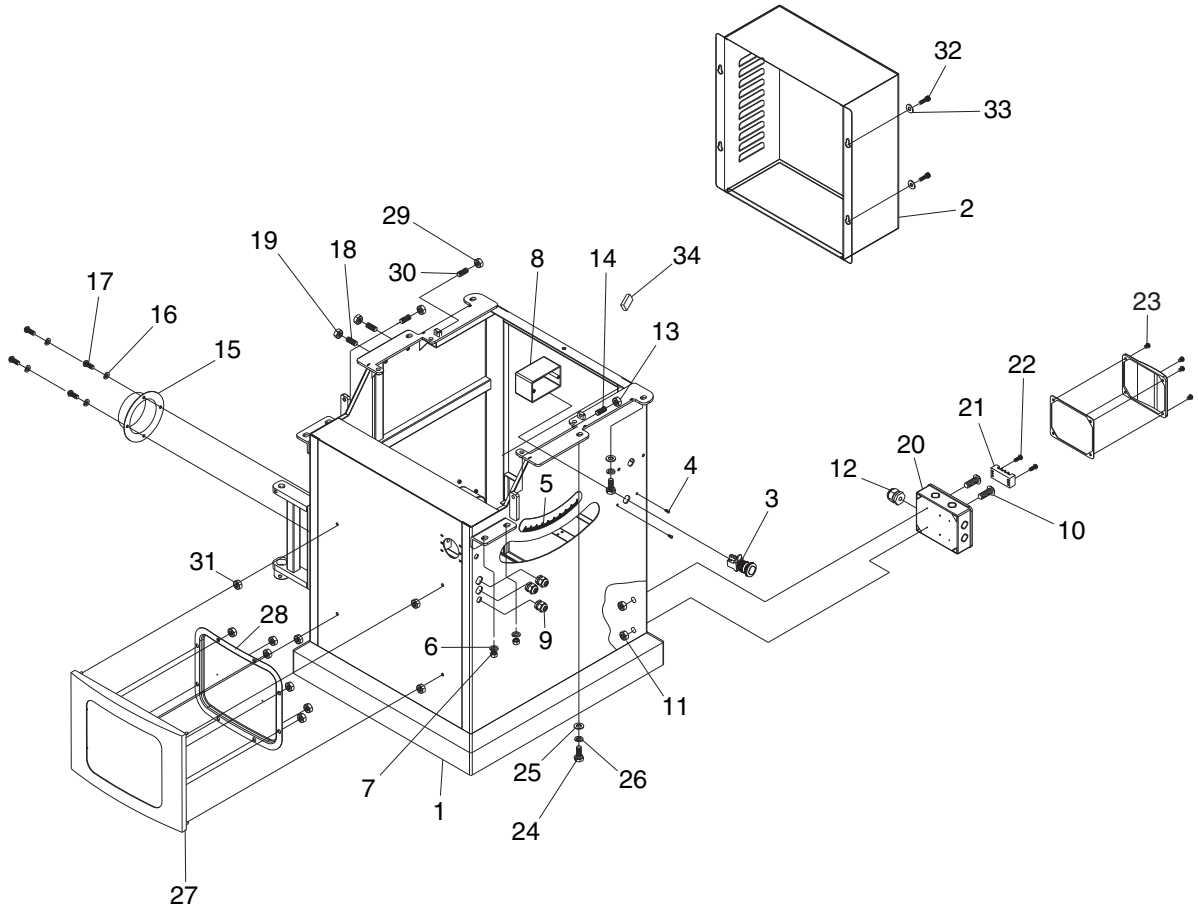


G0623X3 7.5 HP 440V Wiring Diagram



SECTION 8: PARTS

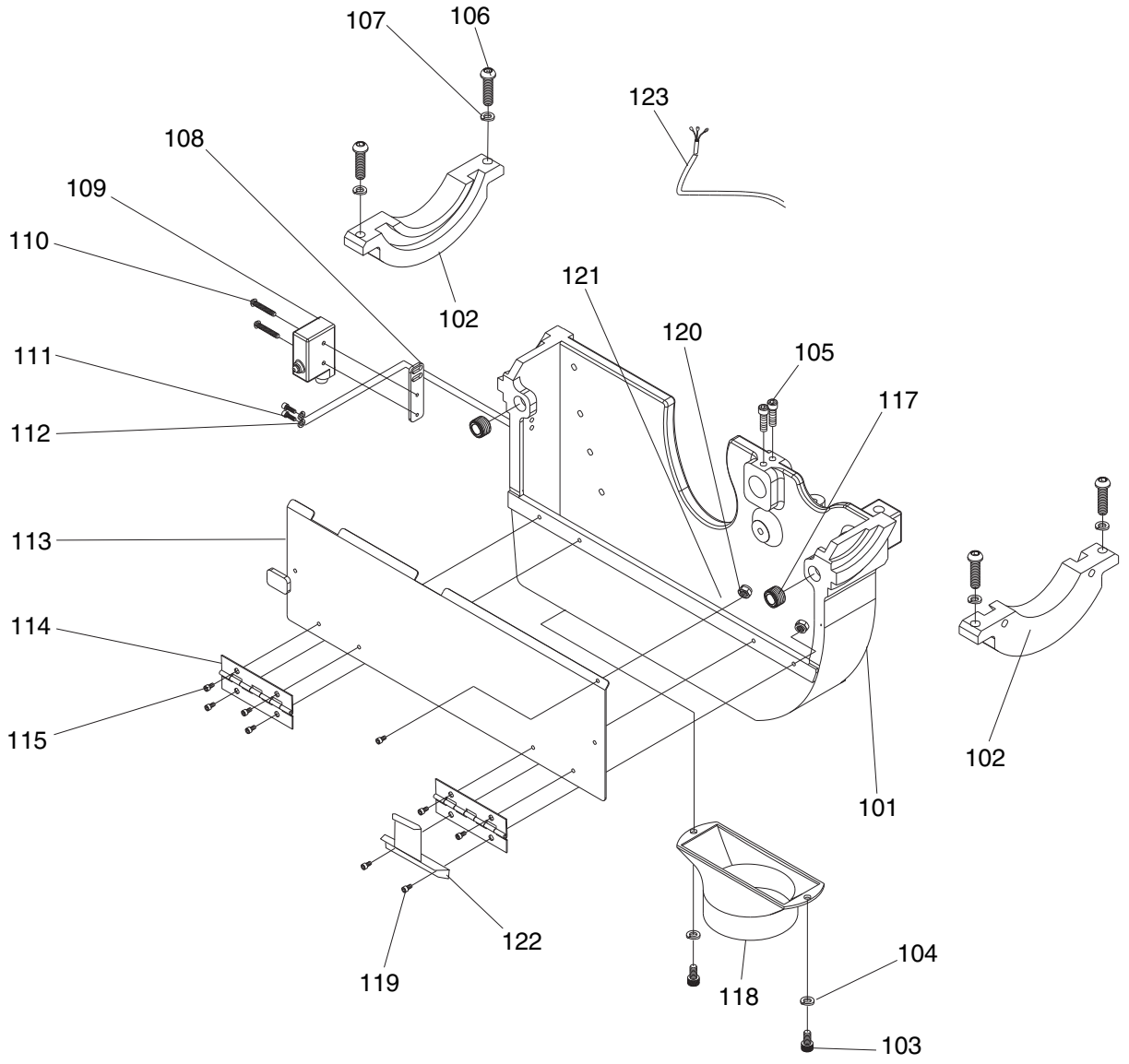
Cabinet



REF	PART #	DESCRIPTION
1	P0623X0001	CABINET
2	P0623X0002	COVER PLATE
3	P0623X0003	EMERGENCY STOP BUTTON
4	PHTEK19M	TAP SCREW M5 X 16
5	P0623X0005	BLADE TILT SCALE
6	PLW06M	LOCK WASHER 10MM
7	PN02M	HEX NUT M10-1.5
8	P0623X0008	SWITCH BOX
9	P0623X0009	STRAIN RELIEF
10	PSBS05M	BUTTON HD CAP SCR M6-1 X 20
11	PN01M	HEX NUT M6-1
12	P0623X0012	STRAIN RELIEF M20
13	PN02M	HEX NUT M10-1.5
14	PSS73M	SET SCREW M10-1.5 X 30
15	P0623X0015	DUST PORT 4"
16	PLW03M	LOCK WASHER 6MM
17	PS11M	PHLP HD SCR M6-1 X 16

REF	PART #	DESCRIPTION
18	PSS21M	SET SCREW M8-1.25 X 25
19	PN03M	HEX NUT M8-1.25
20	P0623X0020	POWER BOX
21	P0623X0021	TERMINAL
22	PS05M	PHLP HD SCR M5-.8 X 8
23	PSBS06M	BUTTON HD CAP SCR M5-.8 X 12
24	PB01M	HEX BOLT M10-1.5 X 30
25	P0623X0025	FENDER WASHER 10MM
26	PLW06M	LOCK WASHER 10MM
27	P0623X0027	DECORATIVE PLATE
28	P0623X0028	PLATE SUPPORT
29	PSS74M	SET SCREW M8-1.25 X 35
30	PN03M	HEX NUT M8-1.25
31	PN01M	HEX NUT M6-1
32	PSB11M	CAP SCREW M8-1.25 X 16
33	PW01M	FLAT WASHER 8MM
34	P0623X0034	WIRE CONNECTOR

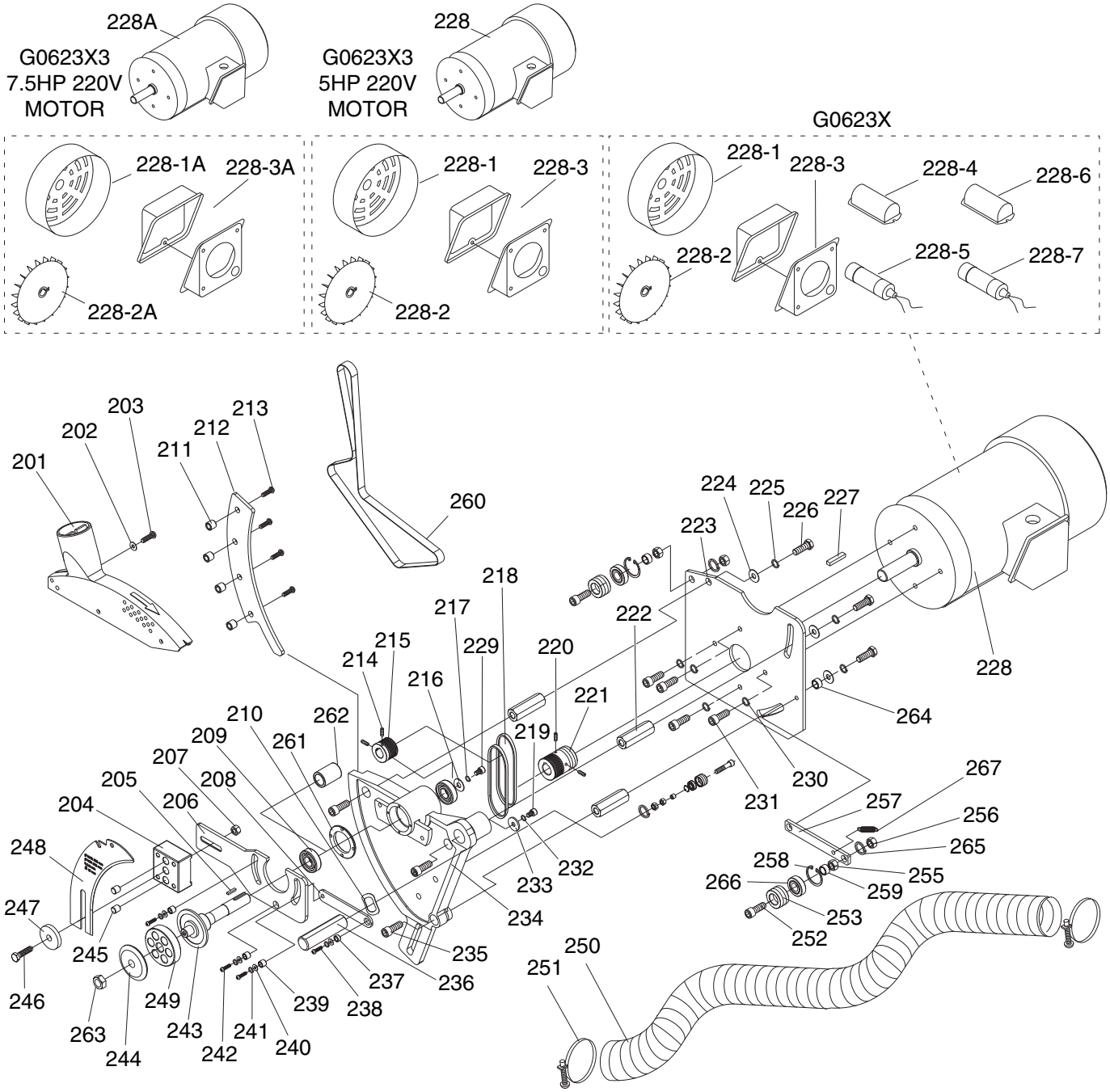
Main Trunnion



REF	PART #	DESCRIPTION
101	P0623X0101	CHANNEL BASE
102	P0623X0102	TRUNNION BRACKET
103	PSB04M	CAP SCREW M6-1 X 10
104	PLW03M	LOCK WASHER 6MM
105	PSB11M	CAP SCREW M8-1.25 X 16
106	PSBS04M	BUTTON HD CAP SCR M8-1.25 X 35
107	PLW04M	LOCK WASHER 8MM
108	P0623X0108	STOP BRACKET
109	P0623X0109	LIMIT SWITCH AZZ7100
110	PS18M	PHLP HD SCR M4-.7 X 25
111	PSB50M	CAP SCREW M5-.8 X 10

REF	PART #	DESCRIPTION
112	PLW04M	LOCK WASHER 8MM
113	P0623X0113	BLADE GUARD PLATE
114	P0623X0114	HINGE
115	PS09M	PHLP HD SCR M5-.8 X 10
117	P0623X0117	MAGNET ASSEMBLY
118	P0623X0118	BLADE SHROUD DUST PORT
119	PS22M	PHLP HD SCR M5-.8 X 25
120	PLN02M	LOCK NUT M5-.8
121	PLW01M	LOCK WASHER 5MM
122	P0623X0122	KEEPER PLATE
123	P0623X0123	CORD

Main Motor


228A
G0623X3
7.5HP 220V
MOTOR
228
G0623X3
5HP 220V
MOTOR
G0623X
228-1A
228-3A
228-2A
228-1
228-3
228-2
228-1
228-3
228-4
228-6
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Main Motor Parts List

REF	PART #	DESCRIPTION
201	P0623X0201	BLADE GUARD COVER
202	P0623X0202	FENDER WASHER 8MM
203	PSBS07M	BUTTON HD CAP SCR M8-1.25 X 40
204	P0623X0204	RIVING KNIFE MOUNTING BLOCK
205	PK34M	KEY 5 X 5 X 20
206	P0623X0206	LOCATING BLOCK
207	PN09M	HEX NUT M12-1.75
208	P0623X0208	LINK PLATE
209	P0623X0209	BALL BEARING 6004LLB
210	P0623X0210	WAVE WASHER 26 X 34MM
211	P0623X0211	COLLAR
212	P0623X0212	GIB PLATE
213	PSBS08M	BUTTON HD CAP SCR M10-1.5 X 35
214	PSS03M	SET SCREW M6-1 X 8
215	P0623X0215	ARBOR PULLEY TYPE M
216	PW06M	FLAT WASHER 12MM
217	PLW04M	LOCK WASHER 8MM
218	PVM20	V-BELT M-20 3L200
219	PSB14M	CAP SCREW M8-1.25 X 20
220	PSS02M	SET SCREW M6-1 X 6
221	P0623X0221	MOTOR PULLEY TYPE M
222	P0623X0222	SHAFT
223	P0623X0223	MAIN MOTOR MOUNTING PLATE
224	PW06M	FLAT WASHER 12MM
225	PLW05M	LOCK WASHER 12MM
226	PB25M	HEX BOLT M12-1.75 X 25
227	PK61M	KEY 7 X 7 X 30
229	PSB14M	CAP SCREW M8-1.25 X 20
230	PLW04M	LOCK WASHER 8MM
231	PSB14M	CAP SCREW M8-1.25 X 20
232	PLW04M	LOCK WASHER 8MM
233	P0623X0233	FENDER WASHER 8MM
234	P0623X0234	ROTATE PLATE

REF	PART #	DESCRIPTION
235	PSB77M	CAP SCREW M12-1.75 X 30
236	P0623X0236	SHAFT
237	P0623X0237	BUSHING
238	PSBS22M	BUTTON HD CAP SCR M8-1.25 X 20
239	P0623X0239	BUSHING
240	P0623X0240	FENDER WASHER 8MM
241	PLW04M	LOCK WASHER 8MM
242	PSBS03M	BUTTON HD CAP SCR M8-1.25 X 16
243	P0623X0243	MAIN ARBOR CSA
244	P0623X0244	ARBOR FLANGE CSA
245	P0623X0245	LOCATING PIN
246	PB73M	HEX BOLT M10-1.5 X 50
247	P0623X0247	RIVING KNIFE WASHER 10MM
248	P0623X0248	RIVING KNIFE
249	P0623X0249	SPECIAL ARBOR WASHER
250	P0623X0250	HOSE 3" X 60CM
251	P0623X0251	HOSE CLAMP 3-1/4"
252	PSB119M	CAP SCREW M12-1.75 X 55
253	P0623X0253	IDLER
255	PN09M	HEX NUT M12-1.75
256	PN09M	HEX NUT M12-1.75
257	P0623X0257	ROTATE PLATE
258	PR20M	INT RETAINING RING 28MM
259	P0623X0259	BUSHING
260	P0623X0260	BELT 15 X 1140
261	P0623X0261	PLATE
262	P0623X0262	BUSHING
263	P0623X0263	LOCK NUT 5/8-11
264	P0623X0264	BUSHING
265	PLW05M	LOCK WASHER 12MM
266	P6001	BALL BEARING 6001ZZ
267	P0623X0267	EXTENSION SPRING

G0623X 5HP, 220V, SINGLE-PHASE MOTOR

REF	PART #	DESCRIPTION
228	P0623X0228	MOTOR 5HP 1-PH
228-1	P0623X0228-1	MOTOR FAN COVER
228-2	P0623X0228-2	MOTOR FAN
228-3	P0623X0228-3	JUNCTION BOX
228-4	P0623X0228-4	CAPACITOR COVER
228-5	P0623X0228-5	S CAPACITOR 400M 250V
228-6	P0623X0228-6	CAPACITOR COVER
228-7	P0623X0228-7	R CAPACITOR 30M 500V

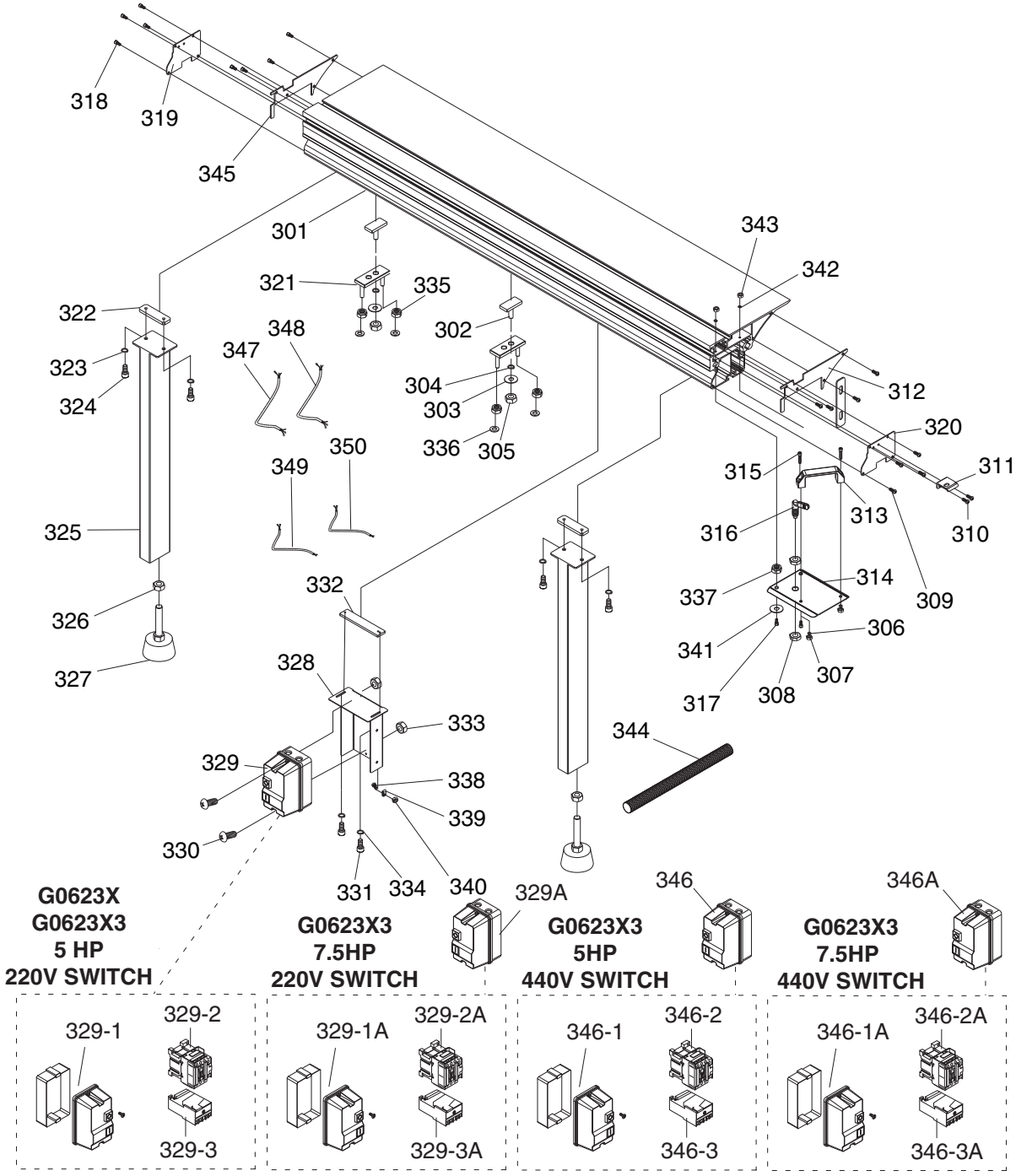
G0623X3 5HP, 220V/440V, 3-PHASE MOTOR

REF	PART #	DESCRIPTION
228	P0623X30228	MOTOR 5HP 220V/440V 3-PH
228-1	P0623X30228-1	MOTOR FAN COVER
228-2	P0623X30228-2	MOTOR FAN
228-3	P0623X30228-3	JUNCTION BOX

G0623X3 7.5HP, 220V/440V, 3-PHASE MOTOR

REF	PART #	DESCRIPTION
228A	P0623X30228A	MOTOR 7.5HP 220V/440V 3-PH
228-1A	P0623X30228-1A	MOTOR FAN COVER
228-2A	P0623X30228-2A	MOTOR FAN
228-3A	P0623X30228-3A	JUNCTION BOX

Sliding Table



Sliding Table Parts List

REF	PART #	DESCRIPTION
301	P0623X0301	SLIDING TABLE SET 688x316
302	P0623X0302	T-SCREW M12-1.75 X 35
303	PW06M	FLAT WASHER 12MM
304	PLW05M	LOCK WASHER 12MM
305	PN09M	HEX NUT M12-1.75
306	PLW03M	LOCK WASHER 6MM
307	PN01M	HEX NUT M6-1
308	PN13M	HEX NUT M16-2
309	PSBS11M	BUTTON HD CAP SCR M6-1 X 10
310	PSBS11M	BUTTON HD CAP SCR M6-1 X 10
311	P0623X0311	LOCATE PLATE
312	P0623X0312	LOCATE PLATE
313	P0623X0313	HANDLE
314	P0623X0314	LOCATE PLATE
315	PSB01M	CAP SCREW M6-1 X 16
316	P0623X0316	PIN LOCK
317	PSB115M	BUTTON HD CAP SCR M6-1 X 16
318	PSBS11M	BUTTON HD CAP SCR M6-1 X 10
319	P0623X0319	SLIDING TABLE END PLATE
320	P0623X0320	SLIDING TABLE END PLATE
321	P0623X0321	LOCATE BLOCK
322	P0623X0322	LOCATE PLATE
323	PLW04M	LOCK WASHER 8MM
324	PSB14M	CAP SCREW M8-1.25 X 20
325	P0623X0325	SUPPORT LEG

REF	PART #	DESCRIPTION
326	PN09M	HEX NUT M12-1.75
327	P0623X0327	ADJUST FOOT
328	P0623X0328	SWITCH MOUNTING BRACKET
330	PS56M	PHLP HD SCR M4-.7 X 16
331	PSB33M	CAP SCREW M5-.8 X 12
332	P0623X0332	LOCATE PLATE
333	PN06M	HEX NUT M5-.8
334	PW02M	FLAT WASHER 5MM
335	PLN05M	LOCK NUT M10-1.5
336	P0623X0336	FENDER WASHER 10MM
337	PFN02M	FLANGE NUT M6-1
338	PSB33M	CAP SCREW M5-.8 X 12
339	PW02M	FLAT WASHER 5MM
340	PN06M	HEX NUT M5-.8
341	PW03M	FLAT WASHER 6MM
342	PLW03M	LOCK WASHER 6MM
343	PN01M	HEX NUT M6-1
344	P0623X0344	FLEXIBLE CONDUIT
345	P0623X0345	LOCATE PLATE
347	P0623X0347	MOTOR CORD 3C 12AWG
347	P0623X30347	MOTOR CORD 4C 12AWG
348	P0623X0348	PWR BOX CORD 3C 12AWG
348	P0623X30348	PWR BOX CORD 4C 12AWG
349	P0623X0349	LIMIT SWITCH CORD 2C 18AWG
350	P0623X0350	E-STOP CORD 2C 18AWG

G0623X 5HP, 220V, 1-PH SWITCH

REF	PART #	DESCRIPTION
329	P0623X0329	SWITCH MP-18 5HP 220V 1PH
329-1	P0623X0329-1	SWITCH BOX
329-2	P0623X0329-2	CONTACTOR SDE MA-18 220V
329-3	P0623X0329-3	RELAY SDE RA-30 22-34 25A

G0623X3 5HP, 220V, 3-PH SWITCH

REF	PART #	DESCRIPTION
329	P0623X30329	SWITCH MP-18 5HP 220V 3PH
329-1	P0623X30329-1	SWITCH BOX
329-2	P0623X30329-2	CONTACTOR SDE MA-18 220V
329-3	P0623X30329-3	RELAY SDE RA-20 12-18 16A

G0623X3 5HP, 440V, 3-PH SWITCH

REF	PART #	DESCRIPTION
346	P0623X30346	SWITCH MP-09 5HP 440V 3PH
346-1	P0623X30346-1	SWITCH BOX
346-2	P0623X30346-2	CONTACTOR SDE MA-09
346-3	P0623X30346-3	RELAY SDE RA-20 8-12 8A

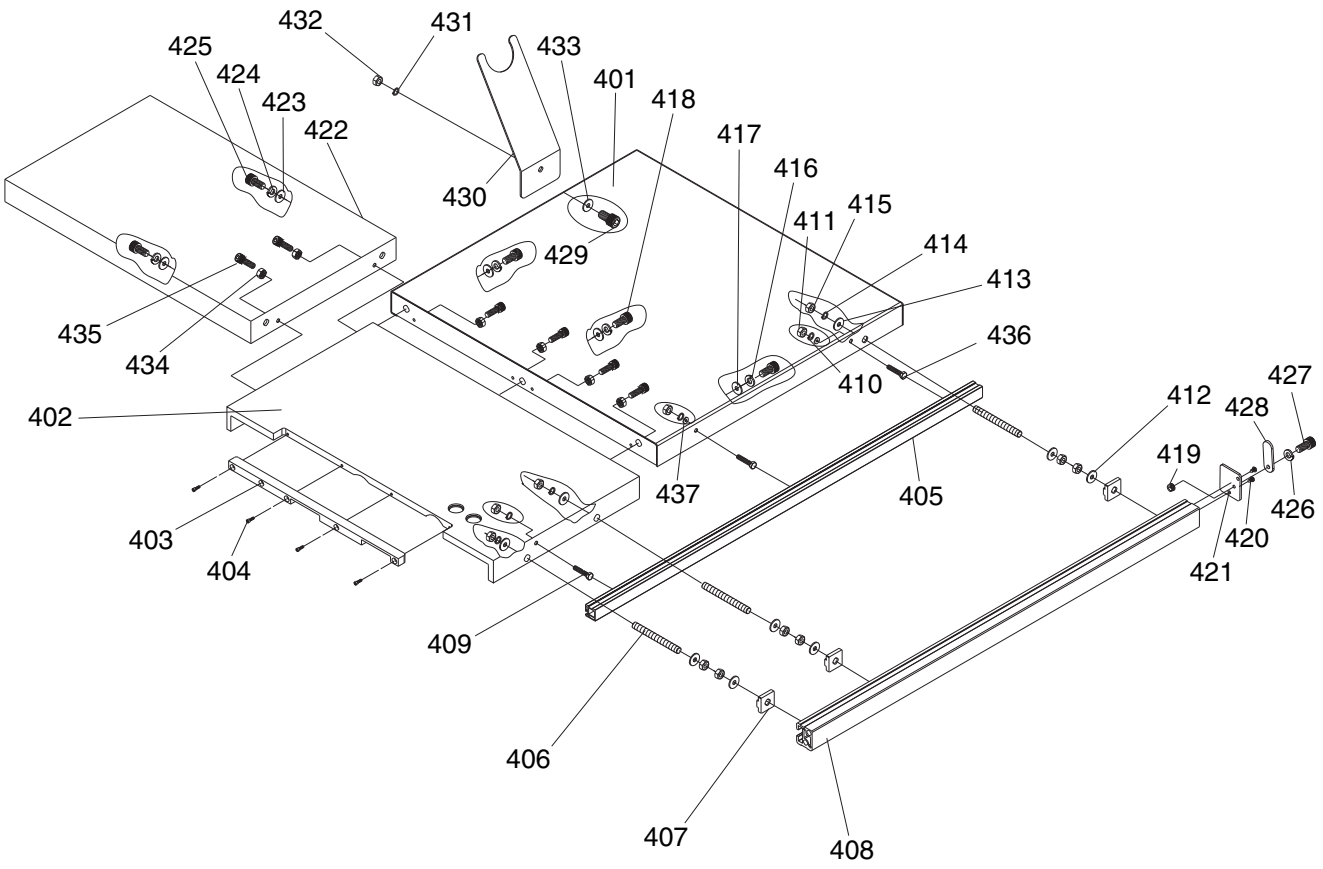
G0623X3 7.5HP, 220V, 3-PH SWITCH

REF	PART #	DESCRIPTION
329A	P0623X30329A	SWITCH MP-18 7.5HP 220V 3PH
329-1A	P0623X30329-1A	SWITCH BOX
329-2A	P0623X30329-2A	CONTACTOR SDE MA-18 220V
329-3A	P0623X30329-3A	RELAY SDE RA-30 18-26 23A

G0623X3 7.5HP, 440V, 3-PH SWITCH

REF	PART #	DESCRIPTION
346A	P0623X30346A	SWITCH MP-18 7.5HP 440V 3PH
346-1A	P0623X30346-1A	SWITCH BOX
346-2A	P0623X30346-2A	CONTACTOR SDE MA-18 440V
346-3A	P0623X30346-3A	RELAY SDE RA-20 12-18 12A

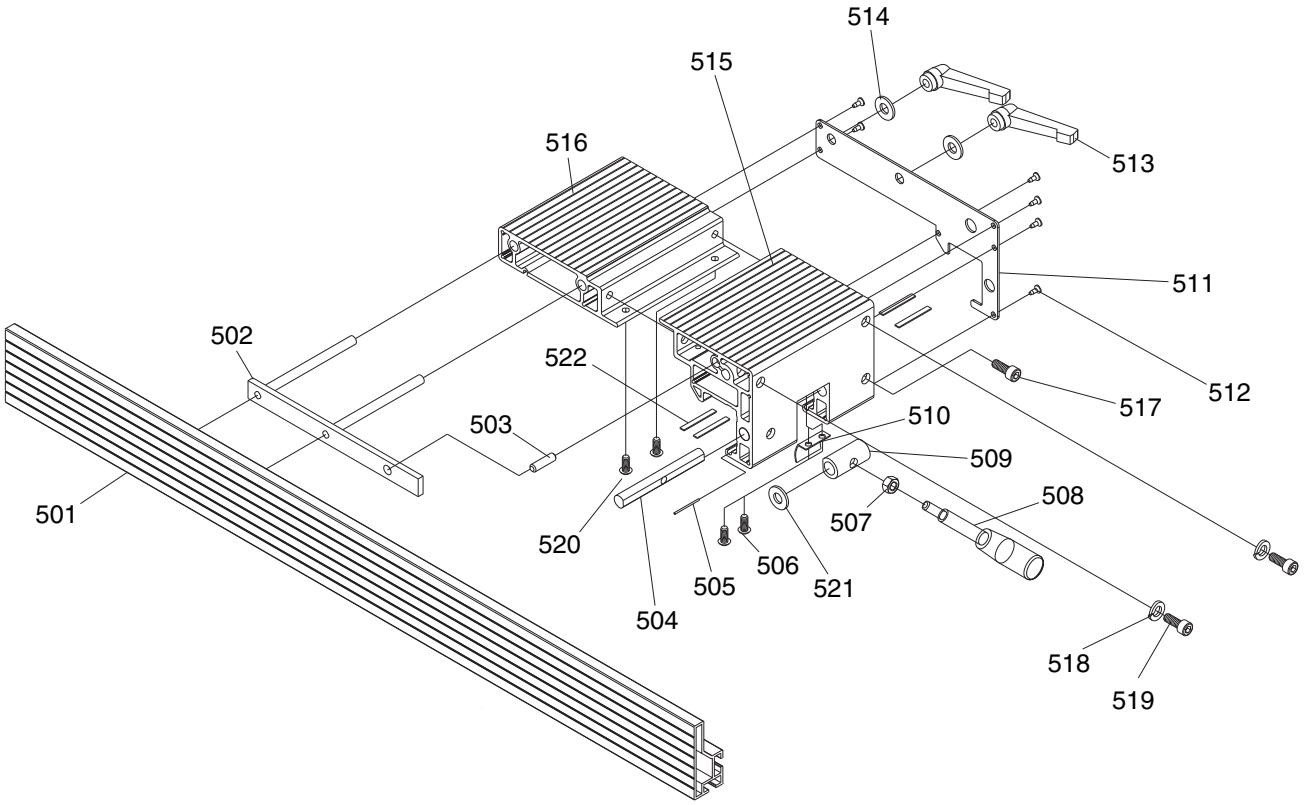
Tables



REF	PART #	DESCRIPTION
401	P0623X0401	LARGE EXTENSION TABLE
402	P0623X0402	CAST IRON TABLE
403	P0623X0403	TABLE INSERT
404	PSB15M	CAP SCREW M5-.8 X 20
405	P0623X0405	RIP FENCE SCALE
406	P0623X0406	STUD M12-1.75 X 90
407	P0623X0407	T-NUT M12-1.75
408	P0623X0408	RIP FENCE RAIL
409	PB10M	HEX BOLT M6-1 X 25
410	PLW03M	LOCK WASHER 6MM
411	PN01M	HEX NUT M6-1
412	PW06M	FLAT WASHER 12MM
413	PW06M	FLAT WASHER 12MM
414	PLW05M	LOCK WASHER 12MM
415	PN09M	HEX NUT M12-1.75
416	PLW06M	LOCK WASHER 10MM
417	PW04M	FLAT WASHER 10MM
418	PSB64M	CAP SCREW M10-1.5 X 25
419	PLN02M	LOCK NUT M5-.8

REF	PART #	DESCRIPTION
420	PHTEK15M	TAP SCREW M4 X 10
421	P0623X0421	RAIL END PLATE
422	P0623X0422	SMALL EXTENSION TABLE
423	PW04M	FLAT WASHER 10MM
424	PLW06M	LOCK WASHER 10MM
425	PSB64M	CAP SCREW M10-1.5 X 25
426	PLW01M	LOCK WASHER 5MM
427	PSBS06M	BUTTON HD CAP SCR M5-.8 X 12
428	P0623X0428	STOP TAB
429	PSB64M	CAP SCREW M10-1.5 X 25
430	P0623X0430	DUST HOSE SUPPORT
431	PLW06M	LOCK WASHER 10MM
432	PLN05M	LOCK NUT M10-1.5
433	PW04M	FLAT WASHER 10MM
434	PN03M	HEX NUT M8-1.25
435	PSB31M	CAP SCREW M8-1.25 X 25
436	PB83M	HEX BOLT M6-1 X 16
437	PW03M	FLAT WASHER 6MM

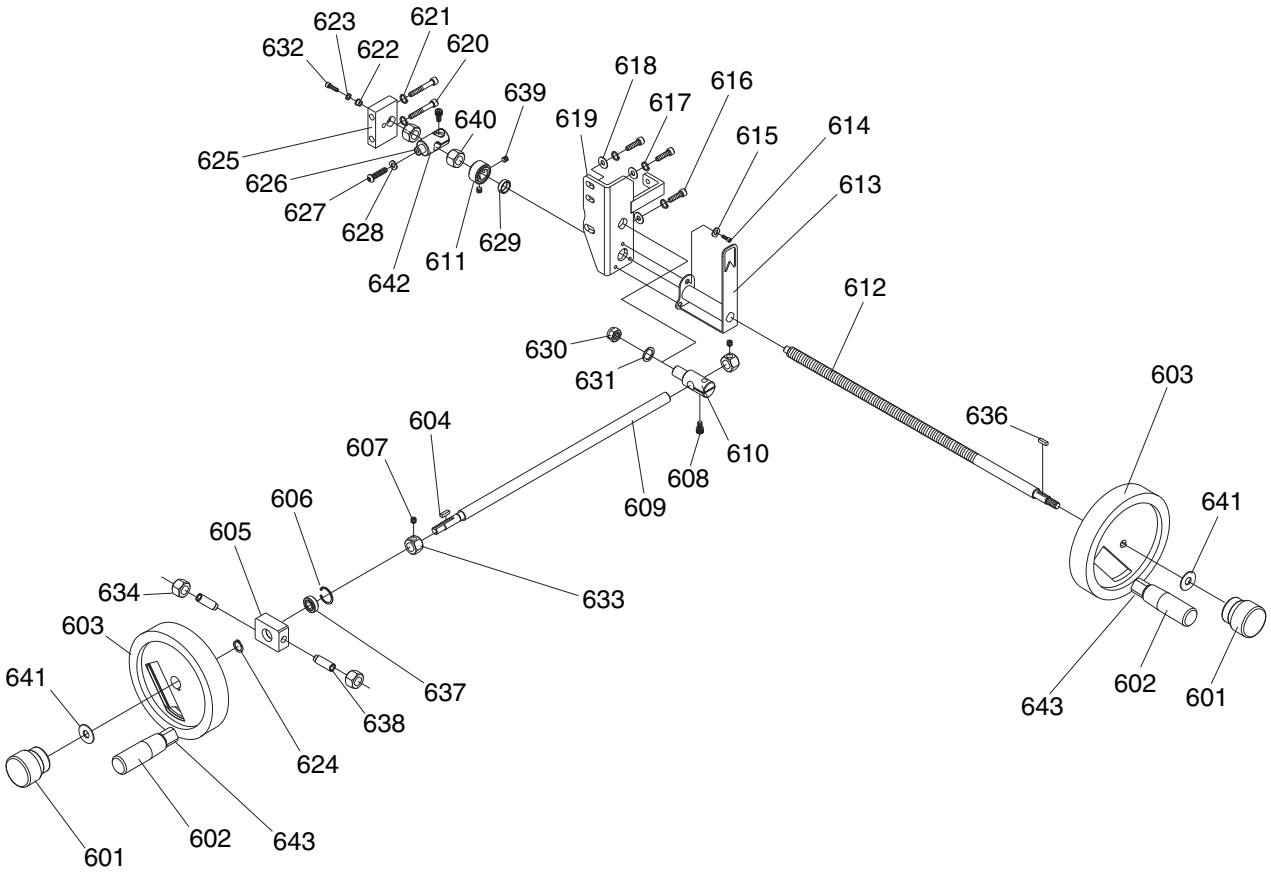
Rip Fence



REF	PART #	DESCRIPTION
501	P0623X0501	RIP FENCE
502	P0623X0502	CLAMP PLATE
503	P0623X0503	STEEL PIN 6MM
504	P0623X0504	ROD
505	P0623X0505	HDPE STRIP
506	PFS07M	FLANGE SCREW M5-.8 X 10
507	PN03M	HEX NUT M8-1.25
508	P0623X0508	FENCE LOCK HANDLE
509	P0623X0509	SLEEVE
510	P0623X0510	SPRING PRESSURE PLATE
511	P0623X0511	COVER PLATE

REF	PART #	DESCRIPTION
512	P0623X0512	TAP SCREW
513	P0623X0513	LOCK PLATE HANDLE M8-1.25
514	PW01M	FLAT WASHER 8MM
515	P0623X0515	RIP FENCE FRONT HOUSING
516	P0623X0516	RIP FENCE REAR HOUSING
517	P0623X0517	PLASTIC SCREW
518	PLW04M	LOCK WASHER 8MM
519	PSB14M	CAP SCREW M8-1.25 X 20
520	P0623X0520	FLAT HD SCR M6-1 X 12
521	P0623X0521	WAVY WASHER 12MM
522	P0623X0522	HDPE STRIP 50 X 5MM

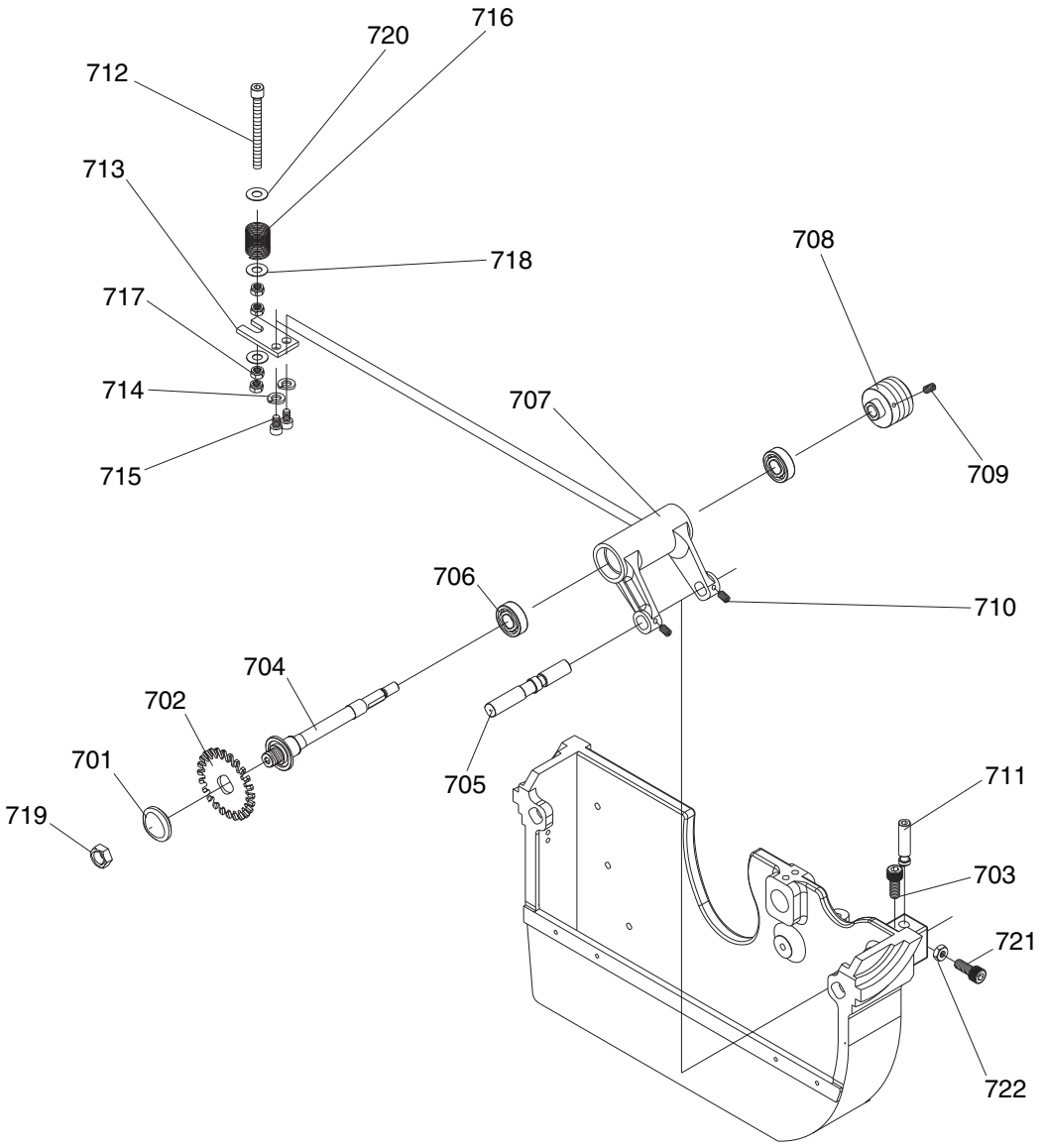
Handwheels



REF	PART #	DESCRIPTION
601	P0623X0601	LOCK KNOB M10-1.5
602	P0623X0602	HANDWHEEL HANDLE
603	P0623X0603	HAND WHEEL
604	PK34M	KEY 5 X 5 X 20
605	P0623X0605	ANGLE SEAT
606	PR20M	INT RETAINING RING 28MM
607	PSS02M	SET SCREW M6-1 X 6
608	PSB61M	CAP SCREW M10-1.5 X 20
609	P0623X0609	SCREW M16 X 2P X 2T
610	P0623X0610	NUT
611	P0623X0611	LOCATE RING
612	P0623X0612	SCREW M16 X 2P X 2T
613	P0623X0613	FINGER GUIDE
614	PSB04M	CAP SCREW M6-1 X 10
615	PLW03M	LOCK WASHER 6MM
616	PSB14M	CAP SCREW M8-1.25 X 20
617	PLW04M	LOCK WASHER 8MM
618	PW01M	FLAT WASHER 8MM
619	P0623X0619	STRUT BOARD
620	PSB05M	CAP SCREW M8-1.25 X 50
621	PLW04M	LOCK WASHER 8MM

REF	PART #	DESCRIPTION
622	P0623X0622	BEARING SELF LUBRICATING
623	PW03M	FLAT WASHER 6MM
624	PR03M	EXT RETAINING RING 12MM
625	P0623X0625	LOCATE BLOCK
626	P0623X0626	LOCATE BLOCK
627	PSB04M	CAP SCREW M6-1 X 10
628	PW03M	FLAT WASHER 6MM
629	P0623X0629	SLEEVE
630	PLN07M	LOCK NUT M16-2
631	P0623X0631	COPPER WASHER 16MM
632	PSB26M	CAP SCREW M6-1 X 12
633	PN13M	HEX NUT M16-2
634	PN09M	HEX NUT M12-1.75
636	PK34M	KEY 5 X 5 X 20
637	P0623X0637	BEARING
638	P0623X0638	SET SCREW M12-1.75 X 35
639	PSS02M	SET SCREW M6-1 X 6
640	PN13M	HEX NUT M16-2
641	P0623X0641	DISC WASHER 10 X 20
642	P0623X0642	BUSHING
643	P0623X0643	HANDLE EXTENSION

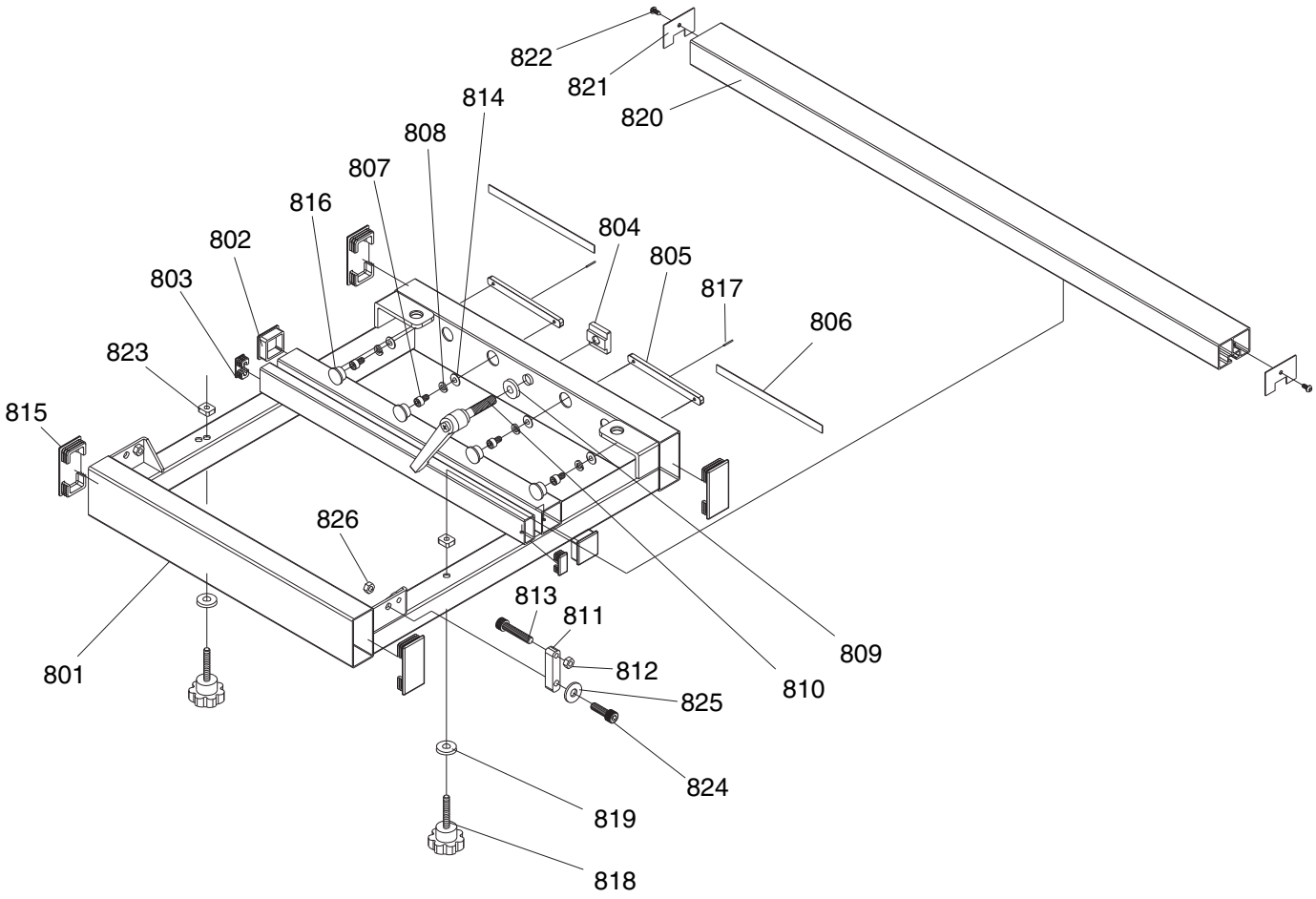
Scoring Trunnion



REF	PART #	DESCRIPTION
701	P0623X0701	ARBOR FLANGE
702	P0623X0702	SCORING SAW BLADE CSA 22MM
703	PSB14M	CAP SCREW M8-1.25 X 20
704	P0623X0704	SHAFT CSA 22MM
705	P0623X0705	SHAFT
706	P0623X0706	BEARING
707	P0623X0707	REGULATOR
708	P0623X0708	SCORING PULLY 60HZ
709	PSS02M	SET SCREW M6-1 X 6
710	PSS02M	SET SCREW M6-1 X 6
711	P0623X0711	ADJUST SHAFT

REF	PART #	DESCRIPTION
712	P0623X0712	ADJUST SCREW M8-1.25 X 100
713	P0623X0713	PLATE
714	PLW04M	LOCK WASHER 8MM
715	PSB31M	CAP SCREW M8-1.25 X 25
716	P0623X0716	LOCK
717	PLN04M	LOCK NUT M8-1.25
718	PW04M	FLAT WASHER 10MM
719	P0623X0719	HEX NUT
720	PW04M	FLAT WASHER 10MM
721	PSB02M	CAP SCREW M6-1 X 20
722	PN01M	HEX NUT M6-1

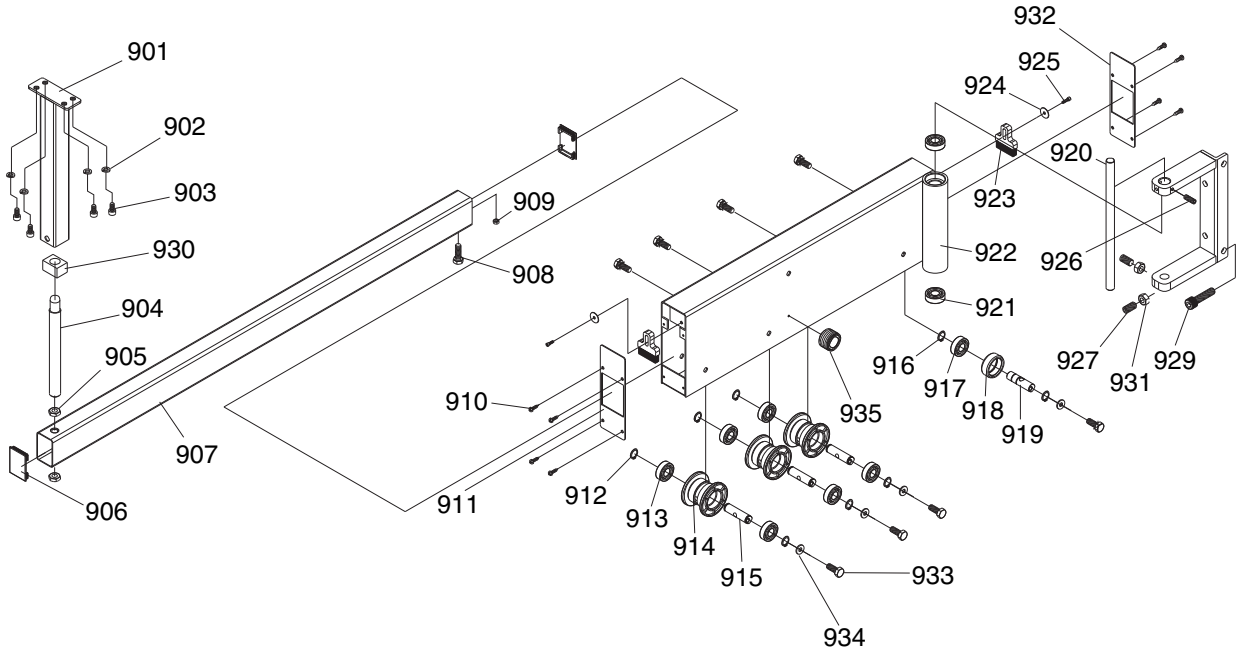
Crosscut Table



REF	PART #	DESCRIPTION
801	P0623X0801	SUPPORT FRAME
802	P0623X0802	PLUG 38 X 38
803	P0623X0803	PLUG 40 X 20
804	P0623X0804	T-NUT M12-1.75
805	P0623X0805	T-SLOT BAR
806	P0623X0806	PAD
807	PSB115M	BUTTON HD CAP SCR M6-1 X 16
808	PLW03M	LOCK WASHER 6MM
809	P0623X0809	FENDER WASHER 12MM
810	P0623X0810	ADJUST HANDLE M12-1.75 X 55
811	P0623X0811	T-NUT
812	PN03M	HEX NUT M8-1.25
813	PB126M	HEX BOLT M8-1.25 X 40

REF	PART #	DESCRIPTION
814	PW03M	FLAT WASHER 6MM
815	P0623X0815	PLUG 80 X 40
816	P0623X0816	PLUG
817	P0623X0817	PIN 3 X 14
818	P0623X0818	KNOB SCREW M8-1.25 X 50
819	P0623X0819	FENDER WASHER 8MM
820	P0623X0820	SQUARE BRACE
821	P0623X0821	COVER
822	P0623X0822	TAP SCREW #8 X 3/8"
823	P0623X0823	T-NUT M8-1.25
824	PSB13M	CAP SCREW M8-1.25 X 30
825	P0623X0825	FENDER WASHER 8MM
826	PLN04M	LOCK NUT M8-1.25

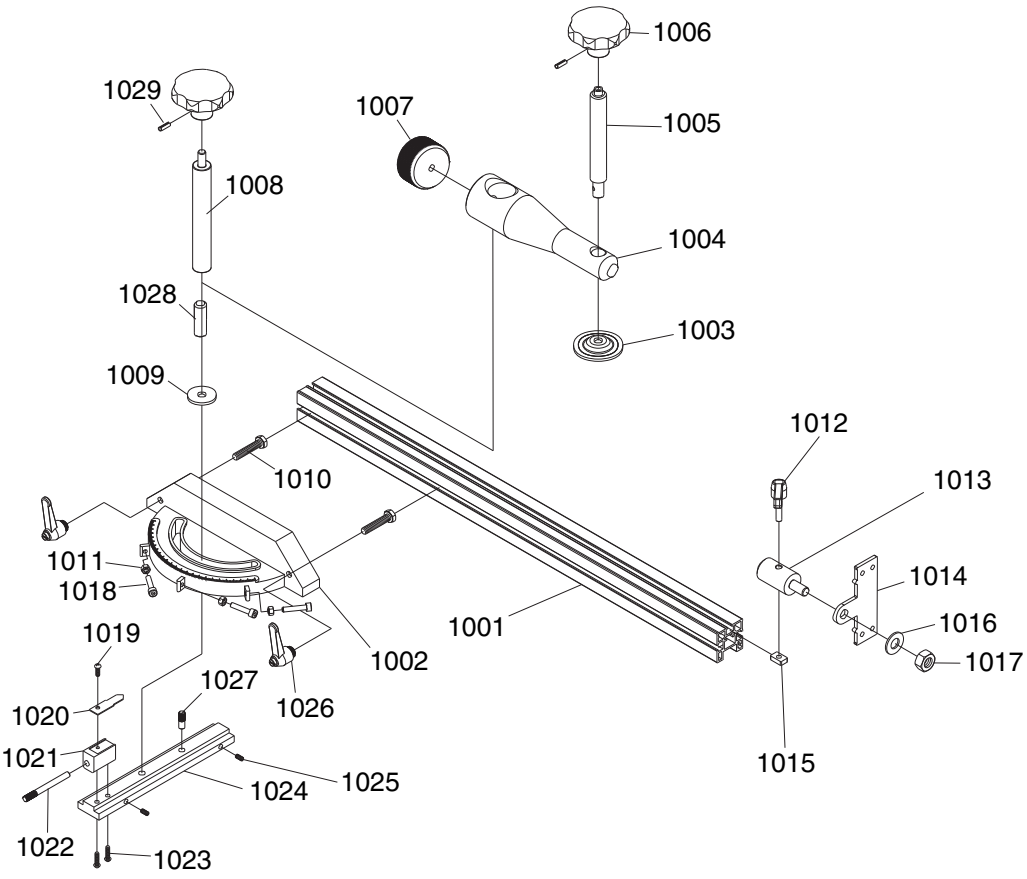
Swing Arm



REF	PART #	DESCRIPTION
901	P0623X0901	FRAME
902	PLW03M	LOCK WASHER 6MM
903	PSB01M	CAP SCREW M6-1 X 16
904	P0623X0904	ROTARY SHAFT
905	PN28M	HEX NUT M20-2.5
906	P0623X0906	PLUG 40 X 80
907	P0623X0907	SLIDING TUBE
908	PB26M	HEX BOLT M8-1.25 X 30
909	PN03M	HEX NUT M8-1.25
910	PHTEK15M	TAP SCREW M4 X 10
911	P0623X0911	COVER
912	PR05M	EXT RETAINING RING 15MM
913	P6202	BALL BEARING 6202ZZ
914	P0623X0914	ROLLER
915	P0623X0915	ADJUST SHAFT
916	PR05M	EXT RETAINING RING 15MM
917	P6202	BALL BEARING 6202ZZ

REF	PART #	DESCRIPTION
918	P0623X0918	RING
919	P0623X0919	ADJUST SHAFT
920	P0623X0920	SET SCREW
921	P6202	BALL BEARING 6202ZZ
922	P0623X0922	SWING ARM
923	P0623X0923	BRUSH
924	PW03M	FLAT WASHER 6MM
925	PSB02M	CAP SCREW M6-1 X 20
926	P0623X0926	SET SCREW
927	P0623X0927	SET SCREW
929	PB14M	HEX BOLT M10-1.5 X 35
930	P0623X0930	PLUG
931	PN02M	HEX NUT M10-1.5
932	P0623X0932	COVER
933	PB09M	HEX BOLT M8-1.25 X 20
934	PW01M	FLAT WASHER 8MM
935	P0623X0935	MAGNET BASE ASSEMBLY

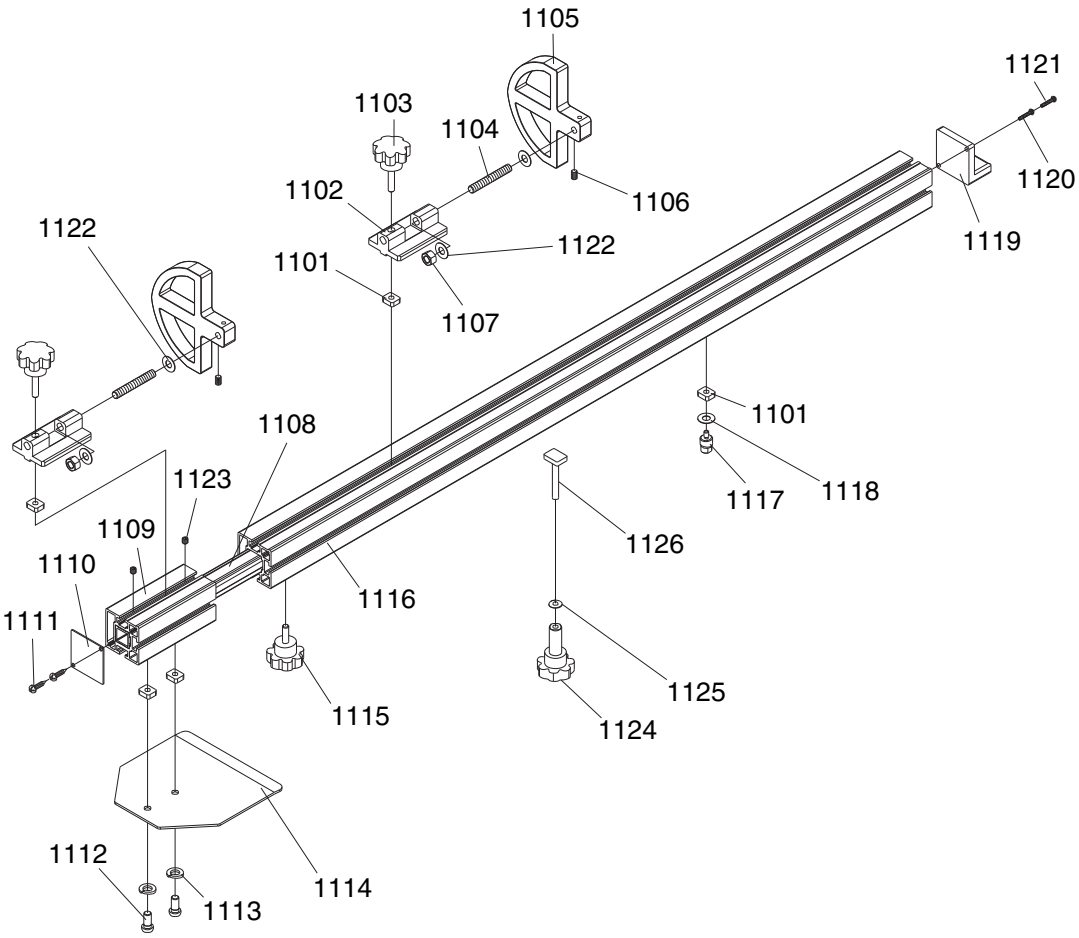
Miter Gauge



REF	PART #	DESCRIPTION
1001	P0623X1001	SQUARE FENCE
1002	P0623X1002	MITER GAUGE BODY
1003	P0623X1003	LARGE WASHER
1004	P0623X1004	BODY
1005	P0623X1005	CLAMP SHAFT
1006	P0623X1006	KNOD SCREW
1007	P0623X1007	KNURLED KNOB
1008	P0623X1008	MITER GAUGE SHAFT
1009	PW01M	FLAT WASHER 8MM
1010	PB29M	HEX BOLT M6-1 X 30
1011	PN06M	HEX NUT M5-.8
1012	P0623X1012	ADJUST HANDLE M6 X 30
1013	P0623X1013	LOCK SHAFT
1014	P0623X1014	STOP PLATE
1015	PSN02M	SQUARE NUT M6-1

REF	PART #	DESCRIPTION
1016	PW04M	FLAT WASHER 10MM
1017	PLN05M	LOCK NUT M10-1.5
1018	PSB38M	CAP SCREW M5-.8 X 25
1019	PS02M	PHLP HD SCR M4-.7 X 12
1020	P0623X1020	POINTER
1021	P0623X1021	FIXED BLOCK
1022	P0623X1022	STOP BAR
1023	PS56M	PHLP HD SCR M4-.7 X 16
1024	P0623X1024	FIXED BASE
1025	PSS23M	SET SCREW M4-.7 X 10
1026	P0623X1026	ADJUST HANDLE
1027	P0623X1027	SHAFT
1028	P0623X1028	SET SCREW M8-1.25 X 45
1029	PRP42M	ROLL PIN 3 X 20

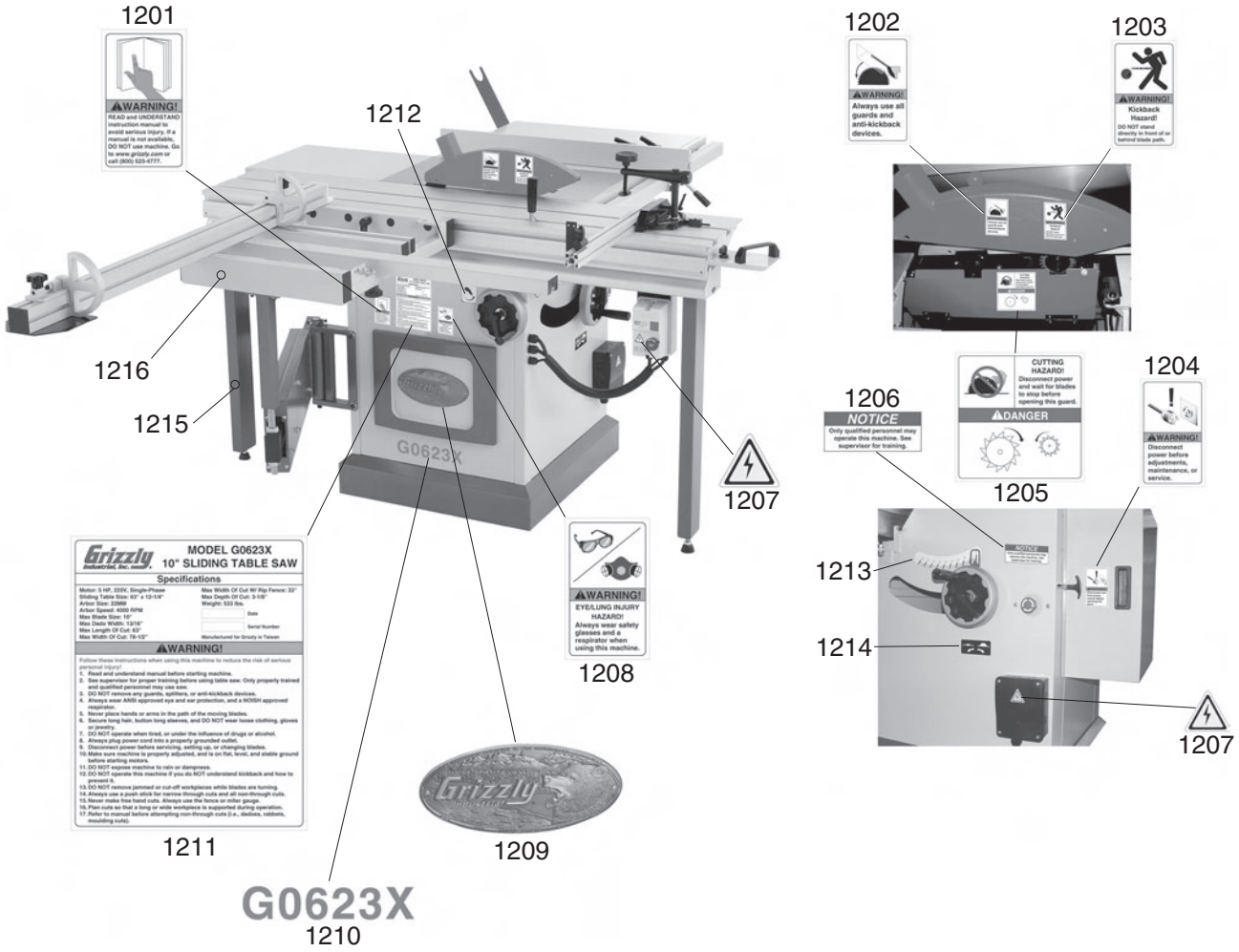
Crosscut Fence



REF	PART #	DESCRIPTION
1101	P0623X1101	T-NUT M8-1.25
1102	P0623X1102	STOP BRACKET
1103	P0623X1103	KNOB M8-1.25 X 40
1104	P0623X1104	SCREW
1105	P0623X1105	FLIP STOP
1106	PSS01M	SET SCREW M6-1 X 10
1107	PLN05M	LOCK NUT M10-1.5
1108	P0623X1108	SQUARE TUBE
1109	P0623X1109	EXT FENCE
1110	P0623X1110	COVER
1111	PHTEK15M	TAP SCREW M4 X 10
1112	PSBS03M	BUTTON HD CAP SCR M8-1.25 X 16
1113	PLW04M	LOCK WASHER 8MM

REF	PART #	DESCRIPTION
1114	P0623X1114	LOCATE PLATE
1115	P0623X1115	KNOB SCREW M8-1.25 X 25
1116	P0623X1116	SQUARE FENCE
1117	P0623X1117	ROTATE SHAFT
1118	P0623X1118	FIBER WASHER 10MM
1119	P0623X1119	ROTATE BLOCK
1120	PS38M	PHLP HD SCR M4-.7 X 10
1121	PS25M	PHLP HD SCR M4-.7 X 35
1122	P0623X1122	FIBER WASHER 10MM
1123	PSS02M	SET SCREW M6-1 X 6
1124	P0623X1124	KNOB SCREW M8-1.25 X 55
1125	P0623X1125	FENDER WASHER 8MM
1126	P0623X1126	T-BOLT M8-1.25 X 60

Labels & Miscellaneous



REF	PART #	DESCRIPTION
1201	PLABEL-12A	READ MANUAL LABEL
1202	P0623X1202	TABLE SAW BLADE GUARD LABEL
1203	P0623X1203	KICKBACK HAZARD LABEL
1204	PLABEL-33	DISCONNECT POWER LABEL
1205	P0623X1205	BLADE GUARD DANGER LABEL
1206	P0623X1206	QUALIFIED PERSONNEL LABEL
1207	PLABEL-14	ELECTRICITY LABEL
1208	PLABEL-37	GLASSES/RESPIRATOR LABEL
1209	G8588	GRIZZLY NAMEPLATE-SMALL

REF	PART #	DESCRIPTION
1210	P0623X1210	MODEL # LABEL (G0623X)
1210	P0623X31210	MODEL # LABEL (G0623X3)
1211	P0623X1211	MACHINE ID LABEL (G0623X)
1211	P0623X31211	MACHINE ID LABEL (G0623X3)
1212	P0623X1212	BLADE TILT LABEL
1213	P0623X1213	BLADE TILT SCALE
1214	P0623X1214	BLADE ELEVATION LABEL
1215	PPAINT-1	GRIZZLY GREEN TOUCH-UP PAINT
1216	PPAINT-11	PUTTY TOUCH-UP PAINT

⚠WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine MUST maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, REPLACE that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.

Grizzly Industrial, Inc. WARRANTY CARD

Name _____

Street _____

City _____ State _____ Zip _____

Phone # _____ Email _____ Invoice # _____

Model # _____ Order # _____ Serial # _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. ***Of course, all information is strictly confidential.***

1. How did you learn about us?

____ Advertisement ____ Friend ____ Catalog
____ Card Deck ____ Website ____ Other:

2. Which of the following magazines do you subscribe to?

____ Cabinet Maker
____ Family Handyman
____ Hand Loader
____ Handy
____ Home Shop Machinist
____ Journal of Light Cont.
____ Live Steam
____ Model Airplane News
____ Modeltec
____ Old House Journal
____ Popular Mechanics
____ Popular Science
____ Popular Woodworking
____ Practical Homeowner
____ Precision Shooter
____ Projects in Metal
____ RC Modeler
____ Rifle
____ Shop Notes
____ Shotgun News
____ Today's Homeowner
____ Wood
____ Wooden Boat
____ Woodshop News
____ Woodsmith
____ Woodwork
____ Woodworker West
____ Woodworker's Journal
____ Other:

3. What is your annual household income?

____ $20,000-$29,000 ____ $30,000-$39,000 ____ $40,000-$49,000
____ $50,000-$59,000 ____ $60,000-$69,000 ____ $70,000+

4. What is your age group?

____ 20-29 ____ 30-39 ____ 40-49
____ 50-59 ____ 60-69 ____ 70+

5. How long have you been a woodworker/metalworker?

____ 0-2 Years ____ 2-8 Years ____ 8-20 Years ____ 20+ Years

6. How many of your machines or tools are Grizzly?

____ 0-2 ____ 3-5 ____ 6-9 ____ 10+

7. Do you think your machine represents a good value? _____ Yes _____ No

8. Would you recommend Grizzly Industrial to a friend? _____ Yes _____ No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
Note: *We never use names more than 3 times.* _____ Yes _____ No

10. Comments: _____

_____

_____

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Place
Stamp
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GRIZZLY INDUSTRIAL, INC.
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BELLINGHAM, WA 98227-2069

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Send a Grizzly Catalog to a friend:

Name_____

Street_____

City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

WARRANTY AND RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

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